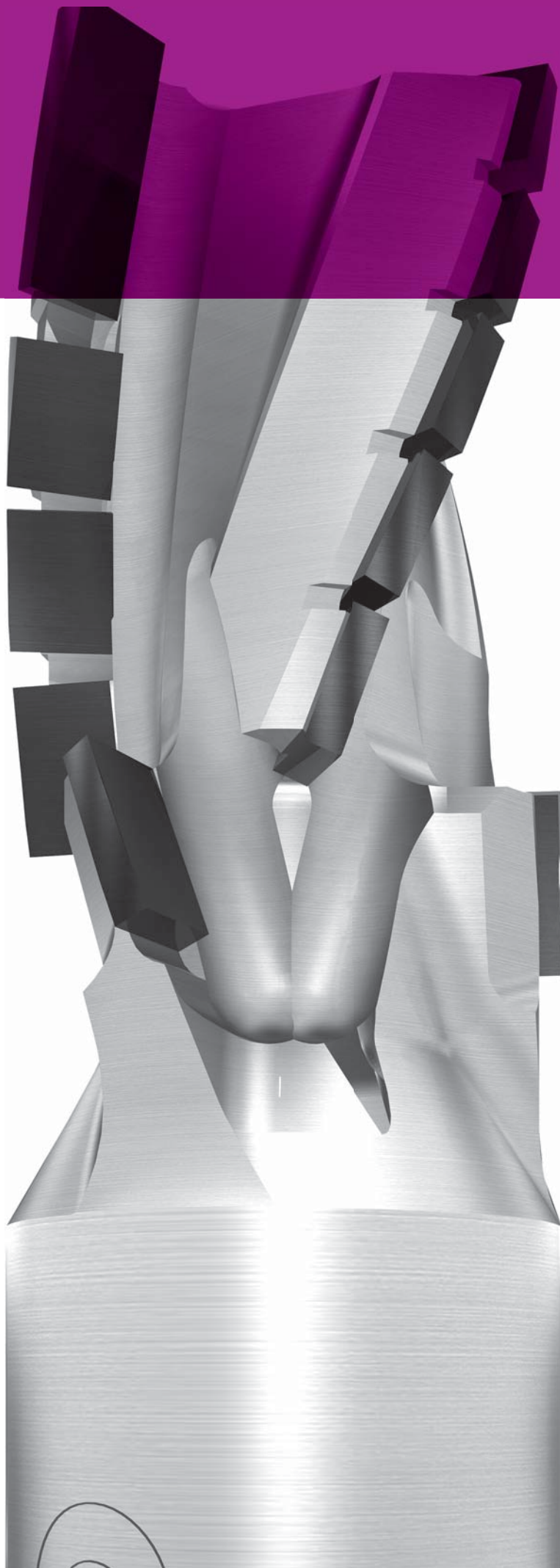




Shank-Type Cutters

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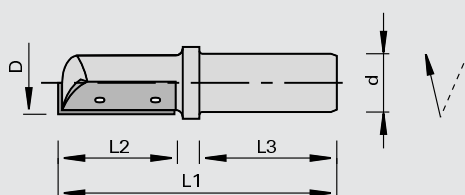
128415

Shank-Type Cutters with HW Turnover Knives - Z=1, MAN

Product



Drawing

LEUCO
CNC

tungsten carbide [HW]

MAN

Machine / Application

- portable routers
- CNC routers
- for jointing, rabbeting and grooving in solid woods and wood-based panels
- for cutting of openings and contours
- traveling plunge cut using Z and X or Y axis

Design

- cutting edge parallel to cutter axis and face cutting
- cutting material: HW HL Board 05

Advantages

Notes

- Clamping elements: ps-System, Tribos, draw-in collet chuck, adapter

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
8	20	9,5	30	60	1		175662
8	20	12	40	70	1		175669
10	25	9,5	30	60	1		175663 o
10	25	10	40	75	1		175678
10	25	12	40	75	1		175670
10	25	16	45	80	1		180797
12	30	12	40	80	1	175665 o	175664
14	30	12	40	80	1	175667 o	175666
16	50	12	40	100	1		175668
[mm]	[mm]	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	Class-No.	Ident-No.
for Ø D = 8	20	4.1	1.1	150535	173480
for Ø D = 10	25	5.5	1.1	150535	173793
for Ø D = 12+14	30	5.5	1.1	150535	173482
for Ø D = 16	50	5.5	1.1	150535	173483
	[mm]	[mm]	[mm]		

Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Clamping Wedges	B=20	175662, 175669	925500	175722 o
Clamping Wedges	B=25	175663, 175670, 175678, 180797	925500	175724 o
Clamping Wedges	B=30	175664	925500	175726 o
Clamping Wedges	B=30	175665	925500	175730 o
Clamping Wedges	B=30	175666	925500	175728 o
Clamping Wedges	B=30	175667	925500	175731 o
Clamping Wedges	B=50	175668	925500	175729 o
Head Cap Screws	M2,5x3 T8	175662, 175669	995115	168237
Head Cap Screws	M2,5x4 T8	175663, 175670, 175678, 180797	995115	168238
Head Cap Screws	M3x5,5 T8	175664, 175665, 175666, 175667	995115	168239
Head Cap Screws	M3,5x5,5 T15	175668	995115	168236
Screwdriver with flag	T8	175662, 175663, 175664, 175665, 175666, 175667, 175669, 175670, 175678, 180797	985730	166499
Screwdrivers	T15	175668	985730	163161
	[mm]			

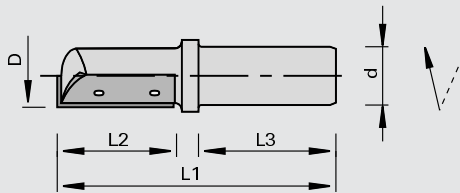
128415

Shank-Type Cutters with HW Turnover Knives - Z=1 with high breaking strength, MAN

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

- portable routers
- CNC routers
- for jointing, rabbeting and grooving in solid woods and wood-based panels
- for cutting of openings and contours
- traveling plunge cut using Z and X or Y axis

Design

- tool body made of heavy metal
- cutting edge parallel to cutter axis and face cutting
- cutting material: HW HL Board 05

Advantages

- high breaking strength

Notes

- Clamping elements: ps-System, Tribos, draw-in collet chuck, adapter

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
8	20	12	40	80	1	180816
10	25	12	40	80	1	180817
12	30	12	40	90	1	180818
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
for Ø D = 8	20	4.1	1.1	150535	173480
for Ø D = 10	25	5.5	1.1	150535	173793
for Ø 12	30	5.5	1.1	150535	173482
	[mm]	[mm]	[mm]		

Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Clamping Wedges	B=20	180816	925500	175722 o
Clamping Wedges	B=25	180817	925500	175724 o
Clamping Wedges	B=30	180818	925500	175726 o
Head Cap Screws	M2,5x3 T8	180816	995115	168237
Head Cap Screws	M2,5x4 T8	180817	995115	168238
Head Cap Screws	M3x5,5 T8	180818	995115	168239
Screwdriver with flag	T8		985730	166499
	[mm]			

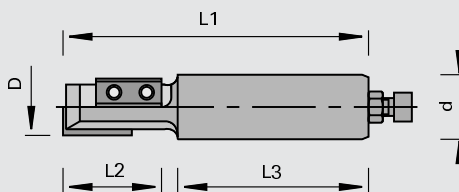
128415

Shank-Type Cutters with HW Turnover Knives - Z=1+1

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for jointing, rabbeting and grooving in solid woods and wood-based panels
- | for cutting of openings and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | cutting edges parallel to cutter axis and face cutting
- | staggered cutting edges
- | cutting material: HW HL Board 05
- | with attachment screw

Advantages

Notes

- | Clamping elements: ps-System, Tribos, draw-in collet chuck, adapter
- | with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
18	45	16	43	106	1+1	168612
18	45	25	55	107	1+1	168611
22	55	25	55	117	1+1	168613
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
	29,5	12	1.5	150515	180825
	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Round Head Screws	M4x5,9 T15	995195	167966
Screwdrivers	T15	985730	163161
	[mm]		

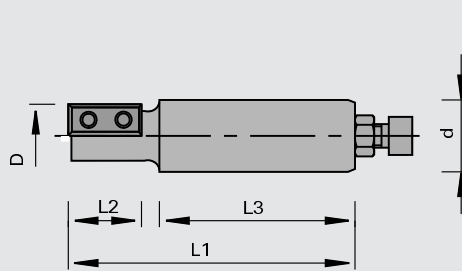
128410

Shank-Type Cutters with HW Turnover Knives - Z=1+1 changeable sense of rotation

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for jointing, rabbeting and grooving in solid woods and wood-based panels
- | for cutting of openings and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | cutting edge parallel to cutter axis and face cutting
- | customized direction of rotation (right or left) by installing the appropriate turnover knife
- | cutting material: HW HL Board 05
- | with attachment screw

Advantages

Notes

- | Clamping elements: ps-System, Tribos, draw-in collet chuck, adapter
- | with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
18	29	25	55	100	1(L+R)	171071
18	50	25	55	120	1(L+R)	171070
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
	29,5	12	1.5	150515	180825
	50	12	1.7	150516	179994
	[mm]	[mm]	[mm]		

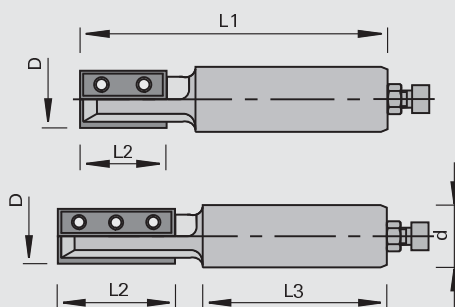
Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Clamping Bars	B=48	171070	925900	171069
Clamping Bars	B=27	171071	925900	171068
Round Head Screws	M3,5x12 T15		995195	171067
Screwdrivers	T15		985730	163161
	[mm]			

128410

Shank-Type Cutters with HW Turnover Knives - Z=2 with mini turnover knives

Product

Drawing



LEUCODUR

tungsten carbide [HW]

MEC

Machine / Application

- CNC routers
- for jointing, rabbeting and grooving in solid woods and wood-based panels
- for cutting of openings and contours
- traveling plunge cut using Z and X or Y axis

Design

- cutting edges parallel to cutter axis; peripheral cutting and face cutting
- cutting material: HW HL Board 05
- cutting material: HW HL Board 03 for abrasive materials, e.g. laminated panel boards
- with attachment screw

Advantages

Notes

- Clamping elements: ps-System, Tribos , draw-in collet chuck, adapter
- with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
16	30	25	55	100	2	180804 o
16	50	25	55	120	2	180805 o
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives

B	H	S	LEUCODUR	Class-No.	Ident-No.
29,5	9	1.5	HL Board 05	150515	180821
29,5	9	1.5	HL Board 03	150513	180807
50	9	1.5	HL Board 03	150516	181982
[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

Ident-No.

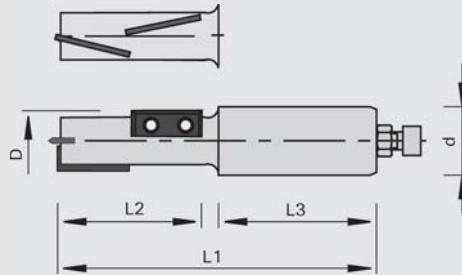
Round Head Screws	M3,5x4,8 T15	995195	180915
Screwdrivers	T15	985730	163161
	[mm]		

128260

Shank-Type Cutters with HW Knives - Z=1+1 with alternating shear angle

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for jointing of chip-free cutting edges in laminated panels
- | for cutting of openings and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | with alternating shear angle
- | plunge tip: Ø 16 - Ø 18 HW-tipped; Ø 30 HW turnover knife
- | with attachment screw

Advantages

- | 2 edge lives by exchanging the upper and lower knife

Notes

- | Clamping elements: ps-System, Tribos, draw-in collet chuck, adapter
- | with attachment screw

Ø D	L2	Ø d	L3	L1	Z		Ident-No.
16	30	25	55	110	1+1	R	180443 o
16	50	25	55	130	1+1	R	180444
18	50	25	55	130	1+1	R	180445 o
[mm]	[mm]	[mm]	[mm]	[mm]			

Knives	B	H	S	Class-No.	Ident-No.
L2 = 30	16	7	1.5	150523	180262
L2 = 50	28	7	1.5	150523	180260
	[mm]	[mm]	[mm]		

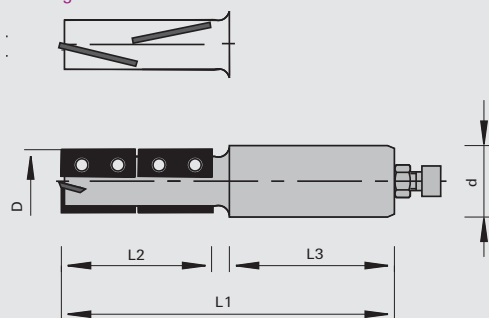
Spare parts	Dimension	Class-No.	Ident-No.
Round Head Screws	M3x4,4 T9	995195	180449
Screwdrivers	T9x60	985730	173796
	[mm]		

128260

Shank-Type Cutters with HW Turnover Knives - Z=2+2 with alternating shear angle

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

| CNC routers
 | for jointing, dividing, grooving
 and rabbeting in laminated
 panels and solid woods
 | traveling plunge cut using Z
 and X or Y axis

Design

| staggered HW knives with with
 alternating shear angle
 | plunge tip: 4-side HW turnover
 knife

Advantages

| 4 edge lives by turning the
 knives and exchanging the
 upper and lower turnover knife

Notes

| Clamping elements: ps-
 System, Tribos , draw-in collet
 chuck
 | with attachment screw

Ø D	L2	Ø d	L3	L1	Z		Ident-No.
20	33	25	55	110	2+2	R	184252
20	33	25	55	110	2+2	L	184255 o
20	53	20	55	125	2+2	R	184253
20	53	25	55	125	2+2	R	184254
20	53	25	55	125	2+2	L	184256 o
30	75	25	55	145	2+2	R	180814 o
[mm]	[mm]	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	Class-No.	Ident-No.
L2 = 33	17,5	7	1.5	150515	184257
L2 = 53	29,5	7	1.5	150515	184258
L2 = 75	39,5	9	1.5	150515	180815
plunge tip for Ø 20	9	9	1.5	150515	184259
plunge tip for Ø 30	7,6	12	1.5	150515	052543
	[mm]	[mm]	[mm]		

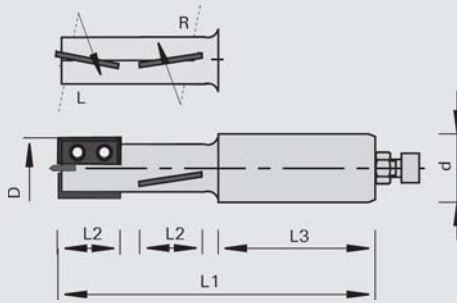
Spare parts	Dimension		Class-No.	Ident-No.
Round Head Screws	M3x4,4 T9	for Ø D = 20	995195	180449
Screwdrivers	T9x60	for Ø D = 20	985730	173796
Head Cap Screws	M3,5x5,5 T15	for Ø D = 30	995115	168236
Head Cap Screws	M4x5 T15	for Ø D = 30	995115	180819 o
Screwdrivers	T15	for Ø D = 30	985730	163161
	[mm]			

128260

Shank-Type Cutters with HW Turnover Knives - Z=2+2, sense of rotation L+R

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

- l CNC routers
- l for jointing, rabbeting and grooving in solid woods and wood-based panels
- l for cutting of openings and contours
- l traveling plunge cut using Z and X or Y axis

Design

- l cutting edges of RH resp. LH cutting parts with down-shear angle
- l lower part of the cutter can be run in left hand rotation by adjusting the Z-axis and changing the direction of rotation; this allows optimum machining of frail edges utilizing only one spindle
- l with attachment screw

Advantages**Notes**

- l workpiece secured on clamping blocks
- l Clamping elements: ps-System, Tribos, draw-in collet chuck
- l with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
20	28	25	55	130	2+2	180442 o
[mm]	[mm]	[mm]	[mm]	[mm]		

Knives	B	H	S	Class-No.	Ident-No.
	28	7	1.5	150523	180260
	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Round Head Screws	M3x4,4 T9	995195	180449
Screwdrivers	T9x60	985730	173796
	[mm]		

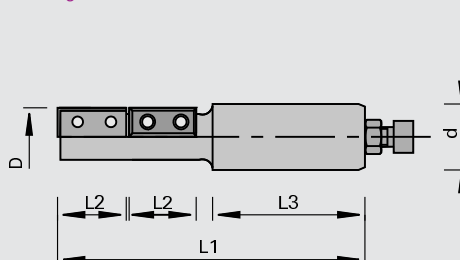
128410

Shank-Type Cutters with HW Turnover Knives - Z=1+1, 2+2 sense of rotation L+R

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

- l CNC routers
- l for jointing, rabbeting and grooving in solid woods and wood-based panels
- l for cutting of openings and contours
- l traveling plunge cut using Z and X or Y axis

Design

- l cutting edges parallel to cutter axis; face cutting
- l customized direction of rotation (right or left) by installing the appropriate turnover knife
- l cutting material: HW HL Board 05
- l lower part of the cutter can be run in left hand rotation by adjusting the Z-axis and changing the direction of rotation; this allows optimum machining of frail edges utilizing only one spindle
- l Ident-No. 172269 with attachment screw
- l Ident-No. 180227 without attachment screw

Advantages

Notes

- l workpiece secured on clamping blocks
- l Clamping elements: ps-System, Tribos, draw-in collet chuck
- l with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
18	29	25	55	132	1L+1R	172269
40	40	25	55	158	2L+2R	180227
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
	29,5	12	1.5	1505 15	180825
	40	12	1.5	1505 15	164078
	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Clamping Bars	B=27	925900	171068
Round Head Screws	M3,5x12 T15	995195	171067
Screwdrivers	T15x80	985730	171188
	[mm]		

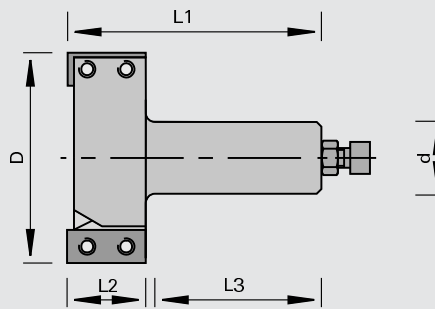
128210

Shank-Type Cutters with HW Turnover Knives for jointing, rabbeting, planing

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

| CNC routers
 | for jointing, rabbeting and planing in solid woods and wood-based panels

Design

| cutting edge parallel to cutter axis and face cutting
 | cutting material: HW HL Board 05
 | with attachment screw

Advantages**Notes**

| Clamping elements: ps-System, Tribos, draw-in collet chuck
 | with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No.		
80	30	25	55	89	2	168732		
[mm]	[mm]	[mm]	[mm]	[mm]				
Turnover Knives				B	H	S	Class-No.	Ident-No.
				29,5	12	1.5	150515	180825
				[mm]	[mm]	[mm]		
Spare parts				Dimension			Class-No.	Ident-No.
Magnetic Stops				1,0			997800	166094
Round Head Screws				M4x5,9 T15			995195	167966
Screwdrivers				T15			985730	163161
				[mm]				

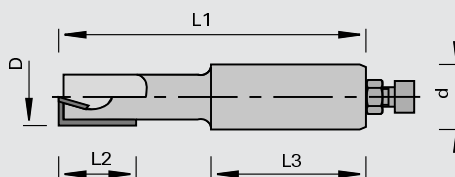
128215

Shank-Type Cutters with HW Turnover Knives - Z=1+1, MEC

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for jointing, rabbeting and grooving in solid woods and wood-based panels
- | for cutting of openings and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | 1 cutting edge parallel to cutter axis and peripheral cutting
- | 1 plunging tip with shear angle
- | cutting material: HW HL Board 05

Advantages

Notes

- | Clamping elements: ps-System, Tribos, draw-in collet chuck
- | with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
16	30	16	43	92	1+1	168682
20	30	16	43	96	1+1	168684
20	30	25	55	108	1+1	168685
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
Plunge tip for Ø 16	7,6	12	1.5	150515	052543
plunge tip for Ø 20	9	12	1.5	150515	167256
Turnover Knives	29,5	12	1.5	150515	180825
	[mm]	[mm]	[mm]		

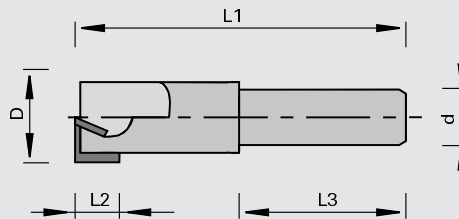
Spare parts	Dimension	Class-No.	Ident-No.
Head Cap Screws	M3,5x3,8 T15	995115	162645
Round Head Screws	M3,5x4 T15	995195	168893
Screwdrivers	T15	985730	163161
	[mm]		

128215

Shank-Type Cutters with HW Turnover Knives - Z=1+1, MAN

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

- portable routers
- CNC routers
- for jointing, rabbeting and grooving in solid woods and wood-based panels
- for cutting of openings and contours
- traveling plunge cut using Z and X or Y axis

Design

- 1 cutting edge parallel to cutter axis and peripheral cutting
- 1 plunging tip with shear angle
- cutting material: HW HL Board 05

Advantages

Notes

- Clamping elements: ps-System, Tribos, draw-in collet chuck, adapter

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
16	12	12	30	70	1+1	180809 o
18	12	12	30	70	1+1	180810 o
20	12	12	30	70	1+1	180811 o
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
plunge tip for Ø 16+18	7,6	12	1.5	150515	052543
plunge tip for Ø 20	9	12	1.5	150515	167256
Turnover Knives	12	12	1.5	150515	003080
	[mm]	[mm]	[mm]		

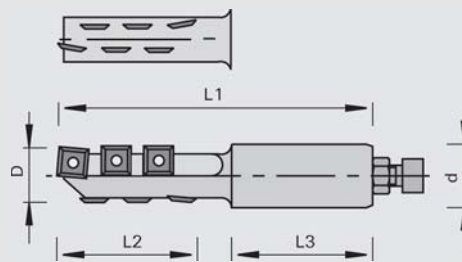
Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Round Head Screws	M4x5,9 T15	180811	995195	167966
Round Head Screws	M3,5x4 T15	180809, 180810	995195	168893
Screwdrivers	T15		985730	163161
Head Cap Screws	M4x5 T15		995115	180819 o
	[mm]			

128210

Shank-Type Cutters with HW Turnover Knives - Z=1+1 with high milling performance

Product

Drawing



tungsten carbide [HW]

MEC

Machine / Application

- l CNC routers
- l for pre-cutting and finish cutting in coated laminated materials
- l traveling plunge cut using Z and X or Y axis

Design

- l upper and lower turnover knife with shear angle
- l cutting material: HW HL Board 05
- l cutting material: HW HL Board 03
- l with attachment screw

Advantages

- l high hogging volume
- l chip-free cutting edges

Notes

- l Clamping elements: ps-System, Tribos, draw-in collet chuck
- l with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
22	42	25	55	115	1+1	180802 o
22	60	25	55	131	1+1	180803 o
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	LEUCODUR	Class-No.	Ident-No.
	12	12	1.5	HL Board 05	150515	003080
	12	12	1.5	HL Board 03	150513	180820
	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	Ident-No.
Round Head Screws	M4x5,9 T15	995195	167966
Screwdrivers	T15	985730	163161
	[mm]		

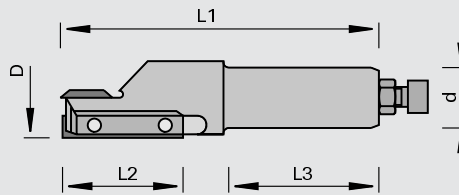
128415

Shank-Type Cutters with HW Turnover Knives - Z=1+1 with mini turnover knives

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for jointing, rabbeting and grooving in solid woods and wood-based panels
- | for cutting of openings and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | 1 cutting edge parallel to cutter axis and peripheral cutting
- | 1 plunging tip
- | cutting material: HW HL Board 05
- | with attachment screw

Advantages

Notes

- | Clamping elements: ps-System, Tribos, draw-in collet chuck, adapter
- | with attachment screw

Ø D	L2	Ø d	L3	L1	Z		Ident-No.
16	30	12	40	81	1+1	L	175706 o
16	30	12	40	81	1+1	R	175705
16	30	16	45	91	1+1	L	175713 o
16	30	16	45	91	1+1	R	175712
16	50	16	45	106	1+1	R	175714
16	50	25	55	116	1+1	R	175715
18	30	12	40	81	1+1	R	175707 o
18	50	16	45	106	1+1	R	180798
18	50	25	55	116	1+1	L	175717
18	50	25	55	116	1+1	R	175716
19.05	50	19,05	50	110	1+1	R	175720 o
20	30	12	40	81	1+1	L	175710 o
20	30	12	40	81	1+1	R	175709 o
20	50	25	55	116	1+1	R	175718 o
22	30	12	40	81	1+1	R	175711 o
[mm]	[mm]	[mm]	[mm]	[mm]			

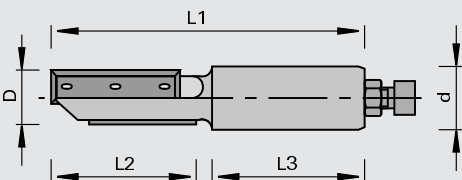
Turnover Knives	B	H	S	Class-No.	Ident-No.
Turnover Knives	12	12	1.5	150515	003080
Mini Turnover Knives	30	5.5	1.1	150535	173482
Mini Turnover Knives	50	5.5	1.1	150535	173483
	[mm]	[mm]	[mm]		

Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Clamping Wedges	B=30	175706, 175713	925500	171117 o
Clamping Wedges	B=30	175705, 175712	925500	169280 o
Clamping Wedges	B=30	175707	925500	169281 o
Clamping Wedges	B=30	175710	925500	171119 o
Clamping Wedges	B=30	175709	925500	169282 o
Clamping Wedges	B=50	175714, 175715	925500	171111 o
Clamping Wedges	B=50	175717	925500	171114 o
Clamping Wedges	B=50	175716, 175720, 180798	925500	171113 o
Clamping Wedges	B=50	175718	925500	171115 o
Clamping Wedges	B=30	175711	925500	169283 o
Head Cap Screws	M3,5x5,5 T15	175705, 175706, 175707, 175712, 175713, 175714, 175715, 175716, 175717, 175720, 180798	995115	168236
Head Cap Screws	M3,5x6,5 T15	175709, 175710, 175711, 175718	995115	163223
Round Head Screws	M4x5,9 T15		995195	167966
	[mm]			

Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Screwdrivers	T15 [mm]		985730	163161

128215

Shank-Type Cutters with HW Turnover Knives - Z=2

Product		Drawing						
						 tungsten carbide [HW] MEC		
Machine / Application		Design		Advantages		Notes		
I CNC routers I for jointing, rabbeting and grooving in solid woods and wood-based panels I for cutting of openings and contours I traveling plunge cut using Z and X or Y axis		I cutting edges parallel to axis in stepped design (Ident-No. 180799 without stepped design) I 1 plunging tip I cutting material: HW HL Board 05 I with attachment screw				I Clamping elements: ps-System, Tribos , draw-in collet chuck I with attachment screw		
Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]	
18	55	25	55	125	2	180906	177156	
20	55	25	55	125	2		177157	
20	55	MK 2	55	153	2		177159 o	
22	55	25	55	125	2		177158 o	
25	50	25	55	119	2		180799	
[mm]	[mm]	[mm]	[mm]	[mm]				
Turnover Knives				B	H	S	Class-No.	Ident-No.
				50	12	1.7	150516	179994
				[mm]	[mm]	[mm]		
Spare parts		Dimension		For Ident-No.		Class-No.		Ident-No.
Screwdrivers		T15				985730		163161
Round Head Screws		M4x5,9 T15		177156, 177157, 177158, 177159, 180906		995195		167966
Head Cap Screws		M4x6 T15		180799		995195		180989 o
		[mm]						

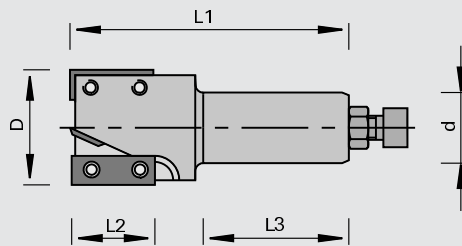
128410

Shank-Type Cutters with HW Turnover Knives - Z=2+1

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for jointing, rabbeting and grooving in solid woods and wood-based panels
- | for cutting of openings and contours
- | traveling plunge cut using Z and X or Y axis

Dimension

- | 2 cutting edges parallel to cutter axis and peripheral cutting
- | 1 plunging tip with shear angle
- | cutting material: HW HL Board 05
- | with attachment screw

Advantages

Notes

- | Clamping elements: ps-System, Tribos, draw-in collet chuck
- | with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
40	30	16	43	91	2+1		168731
40	30	25	55	106	2+1	170815 s	168730
[mm]	[mm]	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	Class-No.	Ident-No.
	12	12	1.5	150515	003080
	29,5	12	1.5	150515	180825
	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Magnetic Stops	1,0	997800	166094
Round Head Screws	M4x5,9 T15	995195	167966
Screwdrivers	T15	985730	163161
	[mm]		

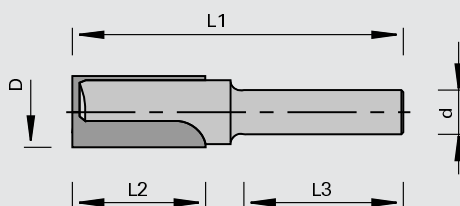
129415

Router Bits HW-tipped - face cutting

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

l routers
l for jointing, rabbeting, grooving
and copying in hard and exotic
woods and wood-based panels

Design

l cutting edges parallel to cutter
axis

Advantages

Notes

l face cutting design allows
plunge-cuts
l clamping elements: centric
clamping chuck, draw-in collet
chuck

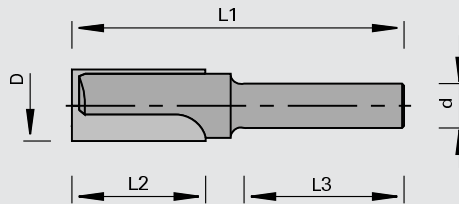
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
10	20	9,5	20	52	2	006227
11	24	9,5	20	52	2	006228
10	23	10	35	70	2	160336
12	23	10	35	70	2	160337
14	23	10	35	70	2	160338
16	23	10	35	70	2	160340
20	23	10	35	70	2	160342
12	26	12	40	72	2	006229
14	28	12	40	76	2	006231
15	30	12	40	80	2	006232
16	35	12	40	90	2	180775
18	35	12	40	90	2	180776
20	35	12	40	90	2	180777
25	41	12	40	92	2	006240
[mm]	[mm]	[mm]	[mm]	[mm]		

129460

Router Bits with solid carbide body - face cutting

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

| routers
 | for jointing, rabbeting, grooving
 and copying in hard and exotic
 woods and wood-based panels

Design

| cutting edges parallel to cutter
 axis

Advantages

Notes

| face cutting design allows
 plunge-cuts
 | clamping elements: centric
 clamping chuck, draw-in collet
 chuck

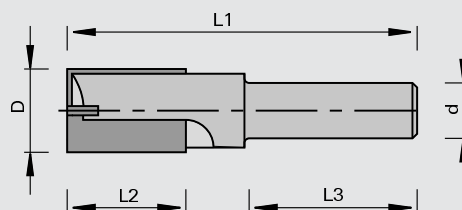
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
3	5	9,5	20	34	2	006219
4	6	9,5	20	37	2	006220
5	7	9,5	20	39	2	006221
8	14	9,5	20	48	2	006225
4	10	10	35	49	2	160332
5	12	10	35	49	2	160333
6	14	10	35	53	2	160334
8	20	10	35	60	2	160335
[mm]	[mm]	[mm]	[mm]	[mm]		

129415

Router Bits HW-tipped - face cutting and plunge tip

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

l routers
l for jointing, rabbeting, grooving
and copying in hard and exotic
woods and wood-based panels

Design

l cutting edges parallel to cutter
axis

Advantages

Notes

l face cutting design and
plunging insert allows
plunge-cuts
l clamping elements: centric
clamping chuck, draw-in collet
chuck

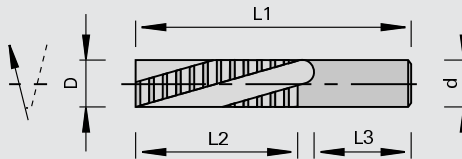
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
10	35	12	50	90	2	177160
12	35	12	50	90	2	177161
12	45	12	50	90	2	177162
14	35	12	50	90	2	177163
16	35	12	50	90	2	177164 o
18	35	12	50	90	2	177165 o
20	35	12	50	90	2	177166 o
22	35	12	50	90	2	177167 o
24	35	12	50	90	2	177168 o
[mm]	[mm]	[mm]	[mm]	[mm]		

129460

Ecoline Roughing Cutters with solid carbide body

Product

Drawing

LEUCO
DUR

Solid Tungsten Carbide

MEC

Machine / Application

- | CNC routers
- | for rough-cutting in solid woods, plywood and uncoated panels
- | for cutting of openings and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | positive spiral for tightly clamped workpieces face side down
- | $n_{max} = 30,000 \text{ min}^{-1}$

Advantages

- | high hogging volume
- | optimum upward chip evacuation thanks to positive spiral
- | well-priced version

Notes

- | Ecoline design = reduced number of traces and less resharpener possibilities
- | slightly rough cutting surface due to fine cut division
- | clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Helical sense	Ident-No.
8	32	8	35	75	3	positive	183950
10	32	10	30	75	3	positive	183951
12	42	12	40	90	3	positive	183952
16	35	16	38	90	3	positive	183953
16	55	16	36	110	3	positive	183954
[mm]	[mm]	[mm]	[mm]	[mm]			

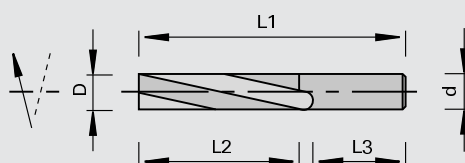
129460

Ecoline Finishing Cutters with solid carbide body

Product



Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- | CNC routers
- | for finish-cutting in solid woods, plywood and uncoated panels
- | for cutting of openings and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | positive spiral for tightly clamped workpieces face side down
- | negative spiral for smaller workpieces hard to clamp with face side up
- | $n_{max} = 30,000 \text{ min}^{-1}$

Advantages

- | high hogging volume
- | optimum upward chip evacuation thanks to positive spiral
- | optimum downward chip evacuation thanks to negative spiral
- | well-priced version

Notes

- | Ecoline design = reduced number of traces and less resharping possibilities
- | clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck

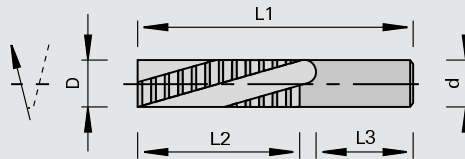
Ø D	L2	Ø d	L3	L1	Z	Helical sense	Ident-No.
3	15	3	36	60	2	positive	183937
3	15	6	36	60	2	positive	183938
4	15	4	36	60	2	positive	183939
4	15	4	28	60	2	negative	183940
4	15	6	36	60	2	positive	183941
5	15	6	36	60	2	positive	183942
6	22	6	30	60	2	positive	183943
6	22	6	30	60	2	negative	183944
8	30	8	36	75	2	positive	183945
8	30	8	36	75	2	negative	183946
10	30	10	35	75	2	positive	183947
10	30	10	36	75	2	negative	183948
12	42	12	40	90	3	positive	183949
[mm]	[mm]	[mm]	[mm]	[mm]			

129460

Roughing Cutters with solid carbide body - negative spiral

Product

Drawing

LEUCO
DUR

Solid Tungsten Carbide

MEC

Machine / Application

- | CNC routers
- | for rough cutting in solid woods, plywood and uncoated panels
- | for cutting of openings and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | negative spiral for smaller workpieces hard to clamp with face side up
- | $n_{max} = 30,000 \text{ min}^{-1}$

Advantages

- | high hogging volume
- | cutting pressure towards the bottom thanks to negative spiral

Notes

- | slightly rough cutting surface due to fine cut division
- | clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
10	30	10	40	75	2	178300
12	42	12	45	90	3	178304
14	35	14	45	90	3	178306 o
16	35	16	48	90	3	178311
16	55	16	48	110	3	178312
18	55	18	48	115	3	178317 o
20	55	20	50	115	3	178320
20	75	20	50	135	3	178323 o
[mm]	[mm]	[mm]	[mm]	[mm]		

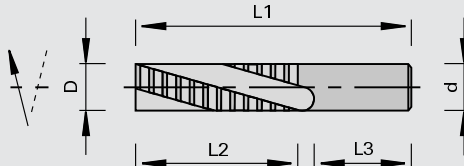
129460

Roughing Cutters with solid carbide body - positive spiral

Product



Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- | CNC routers
- | for rough cutting in solid woods, plywood and uncoated panels
- | for cutting of openings and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | positive spiral for tightly clamped workpieces face side down
- | $n_{max} = 30,000 \text{ min}^{-1}$

Advantages

- | high hogging volume
- | optimum upward chip evacuation thanks to positive spiral

Notes

- | slightly rough cutting surface due to fine cut division
- | clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck

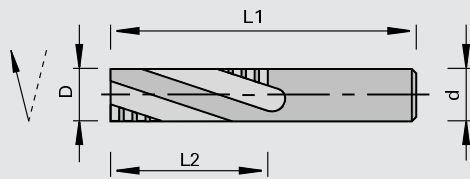
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
12	45	12	45	90	2	178302
12	45	12	45	90	3	178303
10	30	10	40	75	2	178301
14	35	14	45	90	3	178305
14	55	14	45	110	3	178307
16	35	16	48	90	2	178309
16	35	16	48	90	3	178310
16	55	16	48	110	2	178313
16	55	16	48	110	3	178314
18	55	18	48	115	2	178315 o
18	55	18	48	115	3	178316
20	55	20	50	115	2	178318
20	55	20	50	115	3	178319
20	75	20	50	135	2	178321 o
20	75	20	50	135	3	178322
25	55	25	50	115	4	178324
[mm]	[mm]	[mm]	[mm]	[mm]		

129460

Roughing / Finishing Cutters with solid carbide body - positive spiral

Product

Drawing

LEUCO
DUR

Solid Tungsten Carbide

MEC

Machine / Application

| CNC routers
 | for grooving and copying
 | shaping of solid woods and
 | wood-based panels

Design

| Z = 4 (2 roughing and 2
 | finishing knives)
 | n max = 30,000 min⁻¹

Advantages

| high cutting performance
 | optimum lower cutting edge of
 | the workpiece
 | positive spiral direction leads to
 | upward chip ejection

Notes

| roughing knife leads to
 | roughness height of max 0.1
 | mm
 | clamping elements: ps-System
 | with reducing sleeves Class-
 | No. 933280, Tribos, draw-in
 | collet chuck

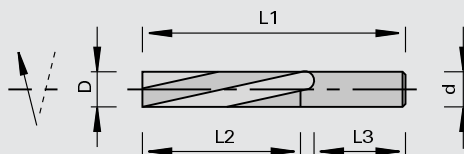
Ø D	L2	Ø d	L1	Z	Ident-No.
12	42	12	90	4	180875
14	50	14	110	4	180876 o
16	55	16	110	4	180877 o
16	35	16	90	4	180878 o
18	55	18	110	4	180879 o
20	60	20	120	4	180880 o
20	70	20	120	4	180881 o
[mm]	[mm]	[mm]	[mm]		

129460

Finishing Cutters with solid carbide body - negative spiral

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- | CNC routers
- | for finish cutting in solid woods and plastic
- | for cutting of openings and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | negative spiral for smaller workpieces hard to clamp with face side up
- | $n_{max} = 30,000 \text{ min}^{-1}$

Advantages

- | cutting pressure and chip evacuation towards the bottom thanks to negative spiral

Notes

- | clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
4	15	4	28	60	2		178326
6	15	6	36	60	2		178327
8	30	8	36	75	2		178330
10	30	10	40	75	2		178332
12	42	12	45	90	2		178335
12	42	12	45	90	3		178336
14	35	14	45	90	2		178338 o
16	35	16	48	90	2		178342
16	35	16	48	90	3		178343
16	55	16	48	110	3	178349 o	178347
20	55	20	50	115	3		178354
20	75	20	50	135	3		178356
[mm]	[mm]	[mm]	[mm]	[mm]			

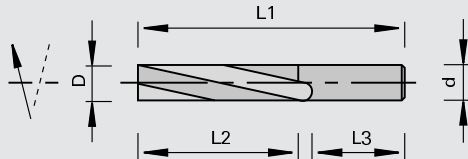
129460

Finishing Cutters with solid carbide body - positive spiral

Product



Drawing

LEUCO
DUR

Solid Tungsten Carbide

MEC

Machine / Application

| CNC routers
 | for finish cutting in solid woods and plastic
 | for cutting of openings and contours
 | traveling plunge cut using Z and X or Y axis

Design

| positive spiral for tightly clamped workpieces face side down
 | $n_{max} = 30,000 \text{ min}^{-1}$

Advantages

| optimal upward chip evacuation thanks to positive spiral

Notes

| clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck

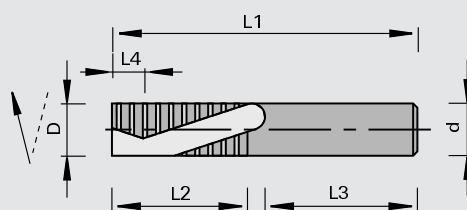
Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
6	15	6	36	60	2		178328
8	30	8	36	75	2		178329
10	30	10	40	75	2		178331
12	42	12	45	90	2		178333
12	42	12	45	90	3		178334
14	35	14	45	90	3		178337
14	55	14	45	110	3		178339
16	35	16	48	90	2		178340
16	35	16	48	90	3		178341
16	55	16	48	110	2		178344
16	55	16	48	110	3	178348	178345
18	55	18	48	115	2		178350 o
18	55	18	48	115	3		178351
20	55	20	50	115	2		178352 o
20	55	20	50	115	3		178353
20	75	20	50	135	3		178355
[mm]	[mm]	[mm]	[mm]	[mm]			

129460

Roughing Cutters with solid carbide body - positive/negative spiral with shear angle

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- l CNC routers
- l for rough cutting of solid wood and plastics
- l for cutting of openings and contours
- l traveling plunge cut using Z and X or Y axis

Design

- l two-sided shear angle
- l $n_{max} = 30,000 \text{ min}^{-1}$

Advantages

- l optimum cutting quality in laminated panels thanks to shear angle

Notes

- l clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck

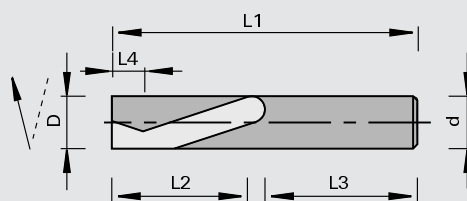
Ø D	L4	L2	Ø d	L3	L1	Z	Ident-No.
20	17	55	20	50	115	2+2	178358
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

129460

Finishing Cutters with solid carbide body - positive/negative spiral with shear angle

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- l CNC routers
- l for finish cutting in solid woods and plastic
- l for cutting of openings and contours
- l traveling plunge cut using Z and X or Y axis

Design

- l two-sided shear angle
- l $n_{max} = 30,000 \text{ min}^{-1}$

Advantages

- l optimum cutting quality in laminated panels thanks to shear angle

Notes

- l clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck

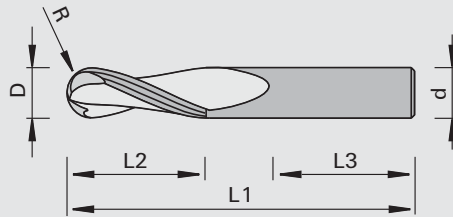
Ø D	L4	L2	Ø d	L1	Z	Ident-No.
8	7	32	8	80	2+2	180870
10	7	32	10	80	2+2	180871
12	7	42	12	90	2+2	180872
16	24	55	16	110	2+2	180873
18	30	55	18	110	2+2	180874
[mm]	[mm]	[mm]	[mm]	[mm]		

129660

Radius Shank-Type Cutter VHW

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

| CNC routers
 | for grooving, contour milling and template copying
 | for milling of contours, surface profiles, string wreaths, and other relief profile milling work
 | traveling plunge cut using Z and X or Y axis

Design

| positive spiral
 | face-ground
 | solid tungsten carbide (VHW)
 | right-hand cutting
 | no. of cutting edges Z=2 resp. Z=3

Advantages

| long edge lives thanks to high-quality micrograin carbide

Notes

| clamping elements: we recommend hydro expansion chuck ps-System, Tribos or heat shrink-fit chuck

Ø D	L2	Ø d	L1	Z	R	Ident-No.
3	12	3	50	2	1,5	185208 o
4	15	4	50	2	2	185209
5	17	5	50	2	2,5	185210 o
6	22	6	60	2	3	185211
8	22	8	70	2	4	185212
10	32	10	70	2	5	185213
10	42	10	100	2	5	185214 o
12	32	12	80	2	6	185215
12	42	12	100	2	6	185216 o
14	42	14	100	2	7	185217 o
16	42	16	100	2	8	185218
16	52	16	100	2	8	185219 o
18	52	18	100	2	9	185220 o
20	52	20	100	2	10	185221
20	72	20	130	2	10	185222 o
[mm]	[mm]	[mm]	[mm]		[mm]	

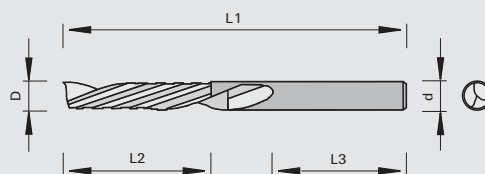
Ø D	L2	Ø d	L1	Z	R	Ident-No.
8	22	8	70	3	4	185223 o
10	32	10	70	3	5	185224 o
10	42	10	100	3	5	185225 o
12	32	12	80	3	6	185226 o
12	42	12	100	3	6	185227 o
14	42	14	100	3	7	185228 o
16	42	16	100	3	8	185229 o
16	52	16	100	3	8	185230 o
18	52	18	100	3	9	185231 o
20	52	20	100	3	10	185232 o
20	72	20	130	3	10	185233 o
[mm]	[mm]	[mm]	[mm]		[mm]	

129464

High-Performance Shank-Type Cutters with solid carbide body for the machining of plastic - Z1

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

| CNC routers
 | for jointing, rabbeting and grooving in plastics
 | traveling plunge cut using Z and X or Y axis

Design

| positive spiral
 | high-polish spiral grooves
 | wear-resistant micrograin carbide HL Board 10

Advantages

| optimal chip removal and excellent cutting quality thanks to specially polished chip gullets and positive spiral

Notes

| negative spiral on request
 | clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck

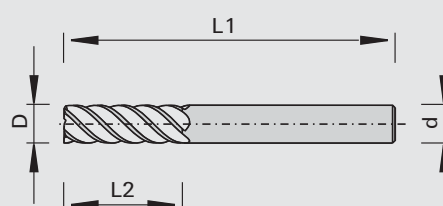
Ø D	L2	Ø d	L1	Z	Helical sense	Ident-No.
3	12	3	50	1	positive	184715
4	15	4	50	1	positive	184716
5	17	5	50	1	positive	184717
6	22	6	60	1	positive	184718
8	22	8	70	1	positive	184719
8	32	8	70	1	positive	184720
10	32	10	70	1	positive	184721
12	32	12	80	1	positive	184722
[mm]	[mm]	[mm]	[mm]			

129460

Polishing Shank-Type Cutter VHW for acrylic glass and PMMA - Z5

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

| CNC routers
 | for finishing of acrylics and PMMA with relatively clear surfaces
 | attention: these tools are not suitable for sizing or dividing but only for polishing!

Design

| positive spiral
 | high-quality solid tungsten carbide (VHW) with 5 cutting edges

Advantages

| reduced production times as postprocessing is no longer necessary
 | produces relatively clear surfaces which are sufficient in many cases

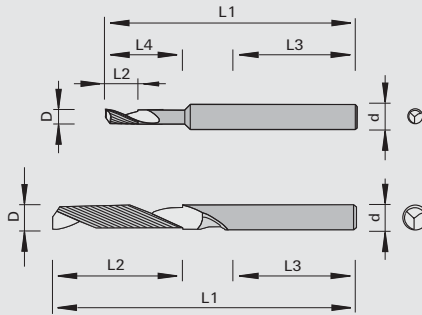
Notes

| finish milling (removal of 0.05 - 0.1 mm) at a feedrate of approx. 0.5 - 1 m/min
 | high RPM is recommended (18,000 - 24,000 min⁻¹ or higher)
 | application against feed
 | the good quality can only be reached in connection with a precision clamping element

Ø D	L2	Ø d	L1	Z	Helical sense	Ident-No.
6	22	6	60	5	positive	184704
8	25	8	70	5	positive	184705
[mm]	[mm]	[mm]	[mm]			

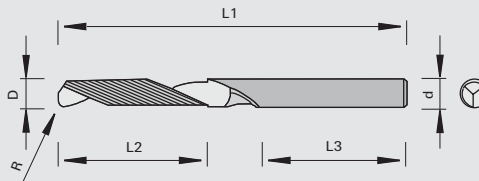
129464

High-Performance Shank-Type Cutters with solid carbide body for the machining of aluminum - Z1

Product		Drawing						
				 Solid Tungsten Carbide MEC				
Machine / Application		Design		Advantages				
- CNC routers - for jointing, rabbeting and grooving in aluminum alloys, copper alloys and NF metals - traveling plunge cut using Z and X or Y axis		- positive spiral - polished chip gullets		optimal chip removal and excellent cutting quality thanks to specially polished chip gullets and positive spiral				
				Notes				
				- negative spiral on request - clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck				
Ø D	L2	L4	Ø d	L3	L1	Z	Helical sense	Ident-No.
3	10	25	8	55	80	1	positive	184709
4	10	25	8	55	80	1	positive	184710
5	10	25	8	55	80	1	positive	184711
6	10	25	8	55	80	1	positive	184712
8	25		8	75	100	1	positive	184713
10	25		10	75	100	1	positive	184714
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

129464

High-Performance Shank-Type Cutters with solid carbide body for the machining of aluminum - Z1 with radius

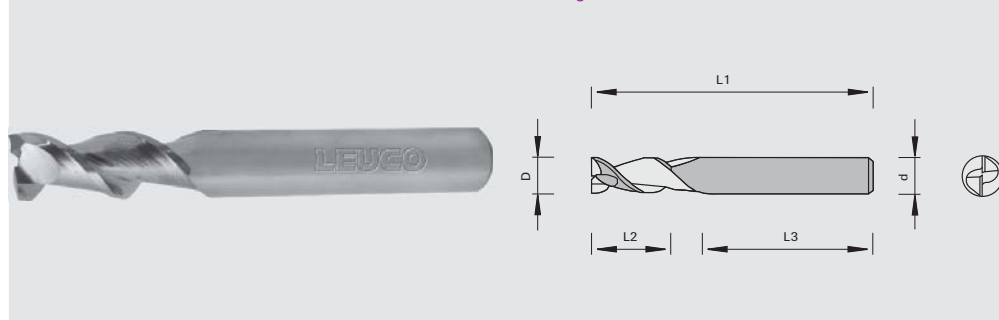
Product		Drawing						
				 Solid Tungsten Carbide MEC				
Machine / Application		Design		Advantages		Notes		
- CNC routers - for jointing, rabbeting and grooving in aluminum alloys, copper alloys and NF metals - especially for grooving in aluminum - traveling plunge cut using Z and X or Y axis		- positive spiral - polished chip gullets		- especially for aluminum with high silicium rate - optimal chip removal and excellent cutting quality thanks to specially polished chip gullets and positive spiral - reduced cutting pressure thanks to radius		- negative spiral or reinforced shank diameter on request - clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck		
Ø D	L2	Ø d	L3	L1	Z	Helical sense	R	Ident-No.
5	20	6	40	70	1	positive	1,0	183972 o
6	20	8	45	80	1	positive	1,5	183973 o
8	22	10	45	90	1	positive	1,5	183974 o
10	25	10	50	100	1	positive	2,0	183975 o
12	30	12	60	120	1	positive	2,5	183976 o
[mm]	[mm]	[mm]	[mm]	[mm]			[mm]	

129464

High-Performance Shank-Type Cutters with solid carbide body for the machining of aluminum - Z2

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

| CNC routers
 | for jointing, rabbeting and grooving in aluminum alloys, copper alloys and NF metals
 | traveling plunge cut using Z and X or Y axis

Design

| positive spiral
 | polished chip gullets
 | spiral angle 45°
 | special grinding

Advantages

| optimal chip removal and excellent cutting quality thanks to specially polished chip gullets and positive spiral

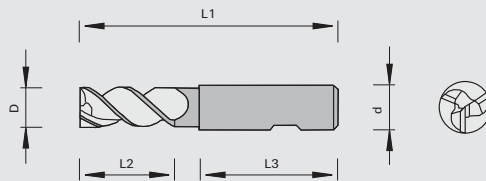
Notes

| negative spiral or reinforced shank diameter on request
 | clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Helical sense	Ident-No.
3	8	6	36	57	2	positive	183977 o
4	11	6	36	57	2	positive	183978 o
5	13	6	36	57	2	positive	183979 o
6	13	6	36	57	2	positive	183980 o
8	19	8	36	63	2	positive	183981 o
10	22	10	40	72	2	positive	183982 o
12	26	12	45	83	2	positive	183983 o
16	32	16	48	92	2	positive	183984 o
20	38	20	50	104	2	positive	183985 o
[mm]	[mm]	[mm]	[mm]	[mm]			

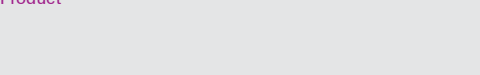
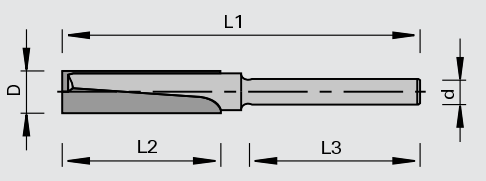
129464

High-Performance Shank-Type Cutters with solid carbide body for the machining of aluminum - Z3

Product		Drawing						
							 Solid Tungsten Carbide MEC	
Machine / Application		Design		Advantages		Notes		
- CNC routers - for jointing, rabbeting and grooving in aluminum alloys, copper alloys and NF metals - traveling plunge cut using Z and X or Y axis		- positive spiral - polished chip gullets - cutting edges with variable pitch - spiral angle 42° - 43° - special grinding		- optimal chip removal and excellent cutting quality thanks to specially polished chip gullets and positive spiral - smooth and low-noise running thanks to variable pitch		- negative spiral or reinforced shank diameter on request - clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck		
Ø D	L2	Ø d	L3	L1	Z	Helical sense	Ident-No.	
3	8	6	45	57	3	positive	183986 o	
4	11	6	39	57	3	positive	183987 o	
5	13	6	39	57	3	positive	183988 o	
6	13	6	39	57	3	positive	183989 o	
8	21	8	38	63	3	positive	183990 o	
10	22	10	42	72	3	positive	183991 o	
12	26	12	47	83	3	positive	183992 o	
16	36	16	50	92	3	positive	183993 o	
20	41	20	52	104	3	positive	183994 o	
[mm]	[mm]	[mm]	[mm]	[mm]				

129815

Router Bits for Sash Openings HW-tipped

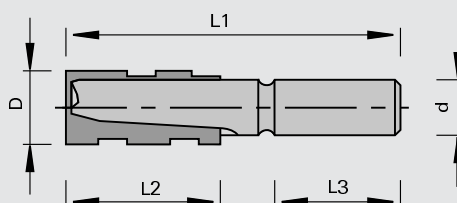
Product		Drawing				LEUCO DUR tungsten carbide [HW] MAN	
							
Machine / Application		Design		Advantages		Notes	
- stationary routers - CNC routers - for cutting of openings in doors, countertops and furniture parts in hard and exotic woods and wood-based panels		cutting edges parallel to cutter axis				- face cutting design allows plunge-cuts - clamping elements: draw-in collet chuck, centric clamping chuck	
Ø D	L2	Ø d	L3	L1	Z	Ident-No.	
14	50	14	40	100	2	058244	
[mm]	[mm]	[mm]	[mm]	[mm]			

129815

Router Bits for Sash Openings HW-tipped with chip breakers

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

| stationary routers
 | CNC routers
 | for cutting of openings in doors, countertops and furniture parts in hard and exotic woods and wood-based panels

Design

| cutting edges parallel to cutter axis with chip breakers

Advantages

| reduced cutting pressure thanks to chip breakers

Notes

| face cutting design allows plunge-cuts
 | clamping elements: draw-in collet chuck, centric clamping chuck

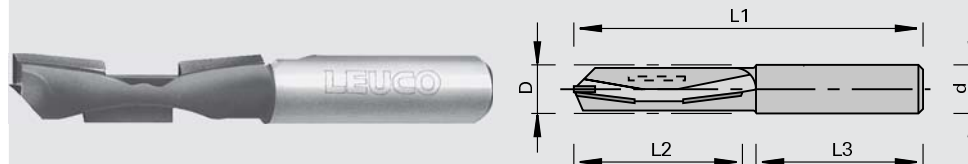
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
14	50	12	20	80	2	167728 s
14	50	14	40	100	2	170733 o
[mm]	[mm]	[mm]	[mm]	[mm]		

129860

Router Bits for Sash Openings HW-tipped with shear angle

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

| stationary routers
 | CNC routers
 | for cutting of openings in doors, countertops and furniture parts in hard and exotic woods and wood-based panels

Design

| with shear angle
 | n max = 16.000 min-1

Advantages

| optimum cutting quality on veneered and plastic laminated parts

Notes

| face cutting design allows plunge-cuts
 | clamping elements: draw-in collet chuck, centric clamping chuck

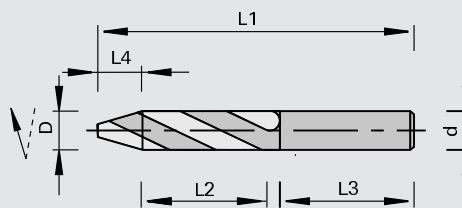
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
14	50	14	48	100	1+1+1	167662
[mm]	[mm]	[mm]	[mm]	[mm]		

129460

Plunge Cutters with solid carbide body - door manufacturing

Product

Drawing

LEUCO
DUR

Solid Tungsten Carbide

MEC

Machine / Application

| CNC machining centers
 | for drilling of peepholes and for
 through holes

Design

| positive spiral
 | $n_{max} = 30,000 \text{ min}^{-1}$

Advantages

Notes

| clamping elements: ps-System
 with reducing sleeves Class-
 No. 933280, Tribos, draw-in
 collet chuck

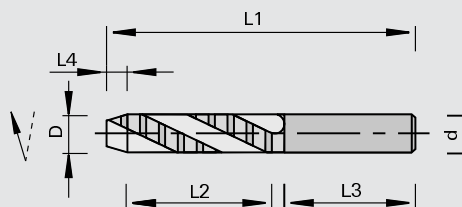
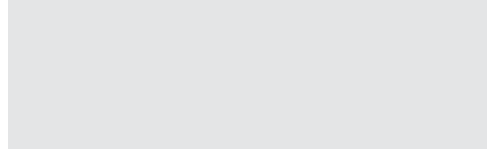
$\emptyset D$	L4	L2	$\emptyset d$	L3	L1	Z	Ident-No.
12	10	47	12	53	110	2	179189
12	10	70	12	50	130	2	179190
14	10	47	14	45	110	2	178359
16	11	52	16	60	130	2	178360
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

129460

Plunge Cutters with solid carbide body - door manufacturing

Product

Drawing

LEUCO
DUR

Solid Tungsten Carbide

MEC

Machine / Application

| CNC machining centers
 | for drilling of latchholes and
 keyholes

Design

| positive spiral
 | $n_{max} = 30,000 \text{ min}^{-1}$

Advantages

Notes

| clamping elements: ps-System
 with reducing sleeves Class-
 No. 933280, Tribos, draw-in
 collet chuck

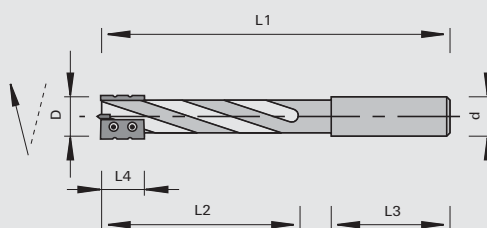
$\emptyset D$	L4	L2	$\emptyset d$	L3	L1	Z	Ident-No.
16	5	75	16	60	130	2	178362
20	5	75	20	60	135	3	179191 o
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

129410

Lock-Case Cutters with HW Knives - door manufacturing

Product

Drawing

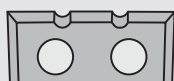
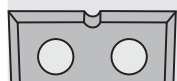
LEUCO
DUR

tungsten carbide [HW]

MEC

A

B



Machine / Application

| CNC machining centers
 | for cutting of lock-cases and
 | face-plates in doors

Design

| positive spiral
 | high-tensile body (heavy metal)
 | with HW-tipped (soldered)
 | plunge tip
 | knives with chip breaker form
 | A and B
 | $n_{max} = 18,000 \text{ min}^{-1}$

Advantages

| optimum chip evacuation thanks
 | to positive spiral
 | high balance quality thanks to
 | cutting edges with chip breakers
 | constant diameter thanks to
 | exchangeable knives

Notes

| clamping elements: ps-System
 | with reducing sleeves Class-
 | No. 933280, Tribos, draw-in
 | collet chuck
 | for attachment in horizontal
 | boring-cutting aggregat (Ho-
 | mag, Weeke) side clamping
 | surfaces are necessary (see
 | Technical Information)

Ø D	L4	L2	Ø d	L3	L1	Z	Ident-No.
16	16	105	16	55	170	2	183750 o
16	16	105	20	55	170	2	183751 o
18	16	105	20	55	170	2	183752 o
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives

B

H

S

Type

Class-No.

Ident-No.

16

7

1.5

A

150525

183753 o

16

7

1.5

B

150525

183754 o

[mm]

[mm]

[mm]

Spare parts

Dimension

Class-No.

Ident-No.

Round Head Screws

M3x4,4 T9

995195

180449

Screwdrivers

T9x60

985730

173796

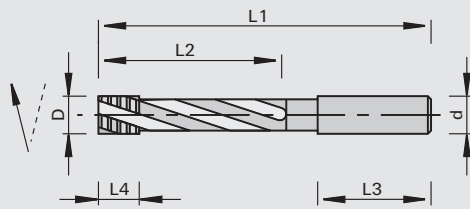
[mm]

129460

Lock-Case Roughing Cutters VHW - door manufacturing

Product

Drawing

LEUCO
DUR

Solid Tungsten Carbide

MEC

Machine / Application

| CNC machining centers
 | for cutting of lock-cases in doors

Design

| positive spiral
 | cutting edges with chip breakers
 | roughing cutter

Advantages

| optimum chip evacuation thanks to positive spiral
 | high balance quality thanks to cutting edges with chip breakers

Notes

| clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck
 | for attachment in horizontal boring-cutting aggregat (Homag, Weeke) side clamping surfaces are necessary (see Technical Information)

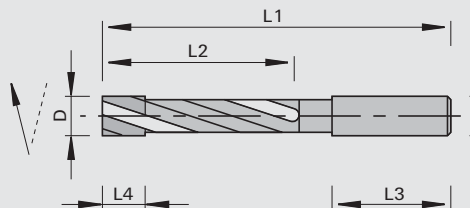
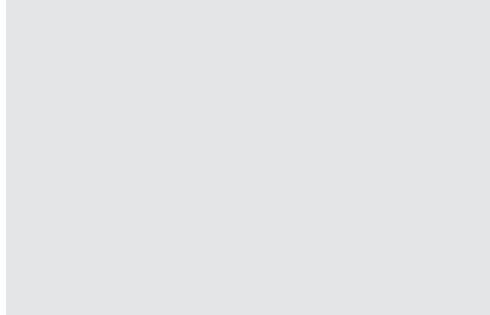
Ø D	L4	L2	Ø d	L3	L1	Z	nmax	Ident-No.
14	25	95	14	50	155	3	24000	178839 o
16	25	115	16	50	175	3	24000	178840
18	25	115	18	50	175	3	24000	178841 o
18	25	115	20	50	175	3	24000	178842
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

129460

Lock-Case Finishing Cutters VHW - door manufacturing

Product

Drawing

LEUCO
DUR

Solid Tungsten Carbide

MEC

Machine / Application

| CNC machining centers
 | for cutting of lock-cases and face-plates in doors

Design

| positive spiral
 | cutting edges with chip breakers
 | serrated cutting edge with chip breakers

Advantages

| optimum chip evacuation thanks to positive spiral
 | high balance quality thanks to cutting edges with chip breakers

Notes

| clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck
 | for attachment in horizontal boring-cutting aggregat (Homag, Weeke) side clamping surfaces are necessary (see Technical Information)

Ø D	L4	L2	Ø d	L3	L1	Z	nmax	Ident-No.
14	25	95	14	50	155	2	24000	178843
16	25	115	16	50	175	2	24000	178958
18	25	115	18	50	175	2	24000	178959 o
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

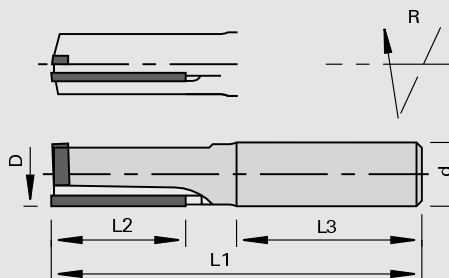
229522

DIAMAX Shank-Type Cutters DP

Product



Drawing

LEUCO
toplineLEUCO
DIAMAX

polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers
 | for jointing and sizing
 without overlap marks in wood-
 based panels, solid woods and
 plastics

Design

| polished face and high-finish
 clearance angle
 | with HW plunge tip for
 diagonal plunge-cutting
 (travelling plunge-cut using Z
 and X axis)
 | straight cutter axis
 | solid carbide body for Ø 8 mm
 and Ø 10 mm
 | resharpening area Ø 8 + Ø 10
 = 0,5 mm - Ø 12 + Ø 16 = 1,2
 mm

Advantages

| high quality machining of MDF
 and hard woods
 | no overlap-marks thanks to
 continuous cutting edge
 | increased stability thanks to
 special design of brazing area

Notes

| Clamping elements: ps-
 System, Tribos , draw-in collet
 chuck
 | with thread for length
 adjusting screw

Ø D	L2	Ø d	L3	L1	Z	n _{max}	Ident-No. [L]	Ident-No. [R]
5	12	12	40	60	1	30000		183566 s
6	12	12	40	60	1	30000		183567
8	12	12	35	60	1	30000	178660 s	178659
8	12	12	40	60	2	30000		183568 s
10	22	12	35	70	2	30000	178769	178661
12	25.4	12	35	70	1	24000		181102
16	25.4	16	45	85	1	24000		181104
16	35	16	45	95	1	24000		181106
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]		

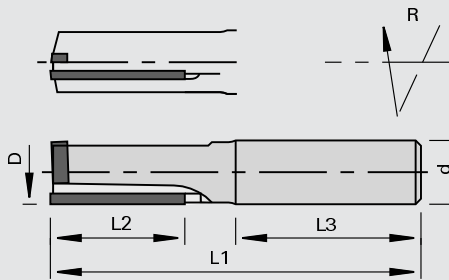
229222

DIAMAX Shank-Type Cutters DP - Z=1

Product



Drawing

LEUCO
toplineLEUCO
DIAMAX

polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers
 | for jointing and sizing without overlap marks in solid woods and wood-based panels

Design

| polished face and high-finish clearance angle
 | with HW plunge tip for diagonal plunge-cutting (travelling plunge-cut using Z and X axis)
 | straight cutter axis
 | resharpening area 1.5 mm

Advantages

| high quality machining of MDF and hard woods
 | no overlap-marks thanks to continuous cutting edge

Notes

| for light millwork only
 | Clamping elements: ps-System, Tribos, draw-in collet chuck
 | with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	n _{max}	Ident-No. [R]
8	22	12	35	65	1	24000	182664
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

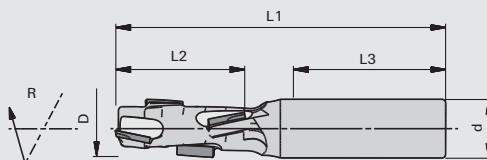
229222

DIAMAX Shank-Type Cutters DP - Z=1+1

Product



Drawing

LEUCO
DIAMAX

polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers
 | for jointing, rabbeting, grooving and copying in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

| with HW plunge tip for diagonal plunge-cutting
 | with shear angle
 | resharpening area 1.5 mm
 | n_{max} = 24,000 min-1

Advantages

| optimum cutting quality thanks to shear angle, alternating top and bottom
 | smooth running thanks to spiral cut configuration
 | very long edge lives, less cutting forces and less noise thanks to optimized tool body

Notes

| feed rates up to 12 m/min
 | clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck
 | with thread for length adjusting screw

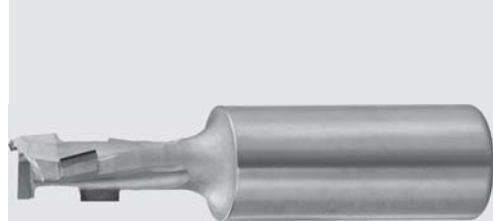
Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
12	22	12	40	69	1+1		183444
12	28	12	40	75	1+1	183443	183442
12	28	20	55	95	1+1	183441	183440
12	28	25	55	95	1+1	183439	183438
16	22	16	45	78	1+1		183437
16	28	16	45	83	1+1		183435
16	35	16	45	90	1+1	183433	183432
16	22	25	55	90	1+1		183436
16	28	25	55	95	1+1		183434
18	28	16	45	85	1+1		183431
[mm]	[mm]	[mm]	[mm]	[mm]			

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
18	35	16	45	92	1+1	183427	183428
18	43	16	45	100	1+1	183423	183422
18	35	20	55	102	1+1		183426
18	43	20	55	110	1+1	183421	183420
18	28	25	55	95	1+1	183429	183430
18	35	25	55	102	1+1	183425	183424
18	43	25	55	110	1+1	183419	183418
20	28	20	55	95	1+1		183797 s
20	35	20	55	102	1+1		183798 s
20	52	25	55	120	1+1	183417	183416
[mm]	[mm]	[mm]	[mm]	[mm]			

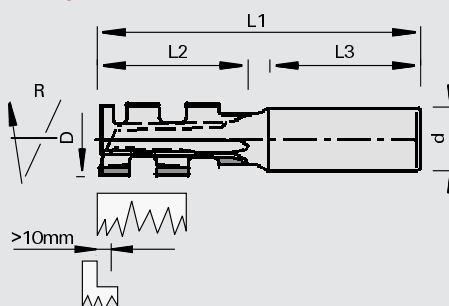
229222

DIAMAX Shank-Type Cutters DP - Z=1+1

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers "Inch-Program"
 | for jointing, rabbeting, grooving
 and copying in raw, melamine-,
 paper-, HPL-laminated, foiled
 and veneered panels

Design

| with HW plunge tip for
 diagonal plunge-cutting
 | with shear angle
 | resharping area 1.5 mm
 | n max = 24,000 min-1

Advantages

| optimum cutting quality thanks
 to shear angle, alternating top
 and bottom
 | smooth running thanks to spiral
 cut configuration
 | very long edge lives, less cutting
 forces and less noise thanks to
 optimized tool body

Notes

| feed rates up to 12 m/min
 | Clamping elements: ps-
 System, Tribos , draw-in collet
 chuck
 | with thread for length
 adjusting screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
1/2	1	1/2	1 3/8	2 2/3	1+1	183445
[inch]	[inch]	[inch]	[inch]	[inch]		

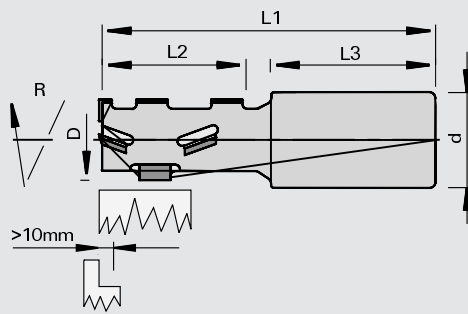
229222

DIAMAX High-Performance Shank-Type Cutters DP - Z=2+2

Product



Drawing

LEUCO
DIAMAX

polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers
 | for jointing, rabbeting, grooving
 and copying in raw, melamine-,
 paper-, HPL-laminated, foiled
 and veneered panels

Design

| with HW plunge tip for
 diagonal plunge-cutting
 | with shear angle
 | resharpening area 1.5 mm
 | n max = 24,000 min-1

Advantages

| optimum cutting quality thanks
 to shear angle, alternating top
 and bottom
 | smooth running thanks to
 4-wing design of cutting edges
 | very long edge lives, less cutting
 forces and less noise thanks to
 optimized tool body

Notes

| feed rates up to 20 m/min
 | Clamping elements: ps-
 System, Tribos, draw-in collet
 chuck
 | with thread for length
 adjusting screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
20	28	20	55	95	2+2	183411	183410
20	38	20	55	105	2+2	183413	183412
20	48	20	55	115	2+2	183415	183414
20	28	25	55	95	2+2	183405	183404
20	38	25	55	105	2+2	183407	183406
20	48	25	55	115	2+2	183409	183408
[mm]	[mm]	[mm]	[mm]	[mm]			

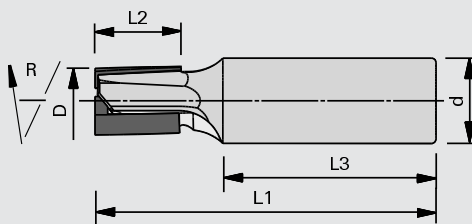
229042

High-Performance Shank-Type Cutters DP - for the machining of solid core panels

Product



Drawing


LEUCO
topline
plus
LEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for jointing and sizing without overlap marks in solid woods and wood-based panels
- | especially suited for the machining of plastic solid core panels (e.g. Trespa, Corian, Varicor, LG-HiMacs, etc.)

Design

- | high-performance tool for pre- and finish-milling
- | with face shear angles
- | with DP plunging tip
- | face cutting for diagonal plunge-cutting
- | polished face
- | n max = 24.000 min-1

Advantages

Notes

- | Clamping elements: ps-System, Tribos, draw-in collet chuck
- | with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	Resharpener area	Ident-No.
12	15	16	45	75	2+1	1.0	R 184202
12	22	16	45	75	2+1	1.0	R 184203
14	28	16	45	80	2+1	1.5	R 184204
16	20	20	50	80	2+1	2.8	R 182640
16	20	20	50	80	3	1.8	R 184206
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	
Ø D	B	Ø d	L3	L1	Z	Resharpener area	Ident-No.
1/2	5/8	1/2	45	3	2+1	1.0	R 184205
[inch]	[inch]	[inch]	[mm]	[inch]		[mm]	

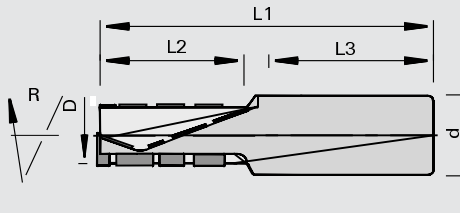
229022

High-Performance Shank-Type Cutters DP - Z=2+1+2

Product



Drawing

LEUCO
toplineLEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers
 | for sizing and dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

| high-performance tool for rough and finish milling
 | Z=1 in middle layer and Z=2 in covering layer
 | face cutting for diagonal plunge-cutting
 | with shear angle
 | resharping area 3.0 mm
 | n max = 30,000 min-1

Advantages

| good cutting quality on top and bottom edge thanks to opposing shear angle
 | reduced vibrations thanks to variable pitch
 | optimum good chip disposal thanks to open arrangement of cutting edges

Notes

| feed speed up to 20 m/min when jointing
 | feed speed up to 12 m/min when sizing
 | Clamping elements: ps-System, Tribos, draw-in collet chuck
 | with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	H	Ident-No. [L]	Ident-No. [R]
20	28	25	60	100	2+1+2	12-25		181481
25	35	25	60	110	2+1+2	18-32		181483
25	42	25	60	120	2+1+2	25-40		181485 s
25	48	25	62	120	2+1+2	32-45	181486	181487
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

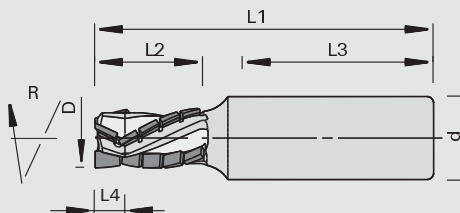
229020

High-Performance Shank-Type Cutters DP - Z=3+3

Product



Drawing

LEUCO
toplineLEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers
 | for sizing and dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels
 | high-performance tool for pre- and finish-milling

Design

| with DP plunge tip for diagonal plunge-cutting
 | with shear angle
 | resharping area 3.0 mm
 | n max = 24,000 min-1

Advantages

| optimum cutting quality thanks to shear angle, alternating top and bottom
 | smooth running thanks to spiral cut configuration

Notes

| feed rates up to 30 m/min
 | Clamping elements: ps-System, Tribos, draw-in collet chuck
 | with thread for length adjusting screw

Ø D	L2	L4	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
18	28	11	25	55	95	3+3	183251 s	183252
20	38	11	20	55	105	3+3	183253 s	183254
25	28	11	25	55	95	3+3	183255	183256
25	38	11	25	55	105	3+3	183257	183258
25	48	11	25	55	115	3+3	183259	183260
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

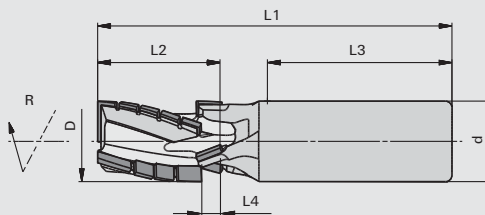
229022

High-Performance Shank-Type Cutters CM DP - Z=3+3

Product



Drawing

LEUCO
toplineLEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

- l CNC routers
- l for sizing and dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels
- l high-performance tool for rough and finish milling

Design

- l with DP plunge tip for diagonal plunge-cutting
- l with shear angle
- l resharpening area approx. 3 mm
- l $n_{max} = 24,000 \text{ min}^{-1}$

Advantages

- l optimum cutting quality thanks to shear angle, alternating top and bottom
- l smooth running thanks to spiral cut configuration
- l optimum chip removal thanks to topward spiral and ChipMeister version

Notes

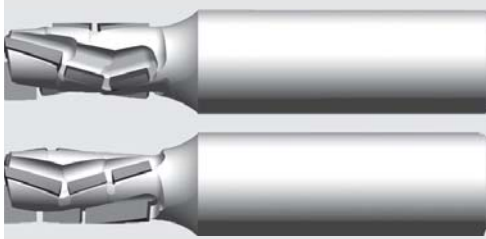
- l feed rates up to 30 m/min
- l Clamping elements: ps-System, Tribos, draw-in collet chuck
- l with thread for length adjusting screw

Ø D	L2	L4	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
20	22	6	25	55	90	3+3	183261 s	183262
20	28	6	25	55	95	3+3	183263 s	183264
25	28	8	25	55	95	3+3	183401 s	183400
20	28	6	20	55	95	3+3	183403 s	183402
20	38	6	20	55	105	3+3	183265 s	183266
25	38	8	25	55	105	3+3	183267	183268
25	52	15	25	55	120	3+3	183269	183270
25	65	15	25	55	133	3+3	183271	183272
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

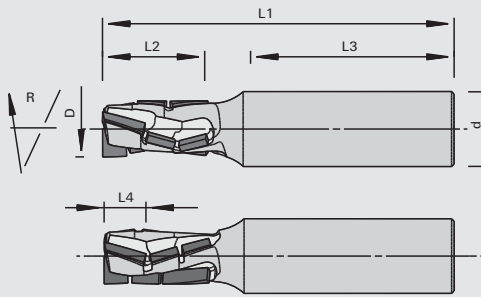
229022

High-Performance Shank-Type Cutters CM DP Nesting - Z=3+3

Product



Drawing

LEUCO
toplineLEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for panel sizing with Nesting-Technology
- | for jointing, rabbeting and *grooving (*negative version) in raw and laminated panels

Design

- | with DP plunge tip
- | face cutting for diagonal plunge-cutting
- | feed rates up to 25 m/min
- | resharpening area 1.6 mm
- | n max = 30,000 min⁻¹

Advantages

- | high cutting quality and high-quality cutting edges thanks to specially adapted cutting edge configuration
- | positive spiral: optimum upward chip evacuation towards the exhaustion
- | negative spiral: downward chip evacuation and cutting pressure
- | negative spiral especially for smaller or narrow workpieces and for grooving

Notes

- | clamping elements: use in high-precision clamping elements recommended (e.g. Tribos, ps-System)
- | with thread for length adjusting screw
- | in case of higher feed rates and thicker boards choose the higher diameter
- | adapt the cutting length to the panel thickness (H)
- | * indicate "H" in case of Nesting with protection board

Ø D	L2	L4	Ø d	L3	L1	Z	H	Helical sense	Ident-No. [R]
12	22		16	45	75	3+3	16-19 *	positive	184185
12	28		16	45	80	3+3	22-25 *	positive	184186
16	22		16	45	75	3+3	16-19 *	positive	184303
16	28		16	45	80	3+3	22-25 *	positive	184187
12	22	10	16	45	75	3+3	-19	negative	184188
16	28	10	16	45	80	3+3	-25	negative	184189
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

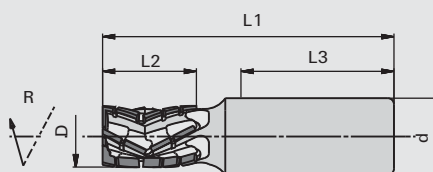
229022

High-Performance Shank-Type Cutters DP - Z=5+5

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

- l CNC routers
- l for sizing and dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels
- l high-performance tool for rough and finish milling

Design

- l arrow-shaped toothing
- l with DP plunge tip for diagonal plunge-cutting
- l with shear angle
- l resharping area approx. 2 mm
- l n max = 24,000 min⁻¹

Advantages

- l optimum cutting quality thanks to shear angle, alternating top and bottom
- l very long edge lives and continuous high cutting quality
- l smooth running thanks to spiral cut configuration

Notes

- l Clamping elements: ps-System, Tribos, draw-in collet chuck
- l with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [R]
20	30	25	55	95	5+5	183172 s
20	35	25	55	100	5+5	183173 s
[mm]	[mm]	[mm]	[mm]	[mm]		

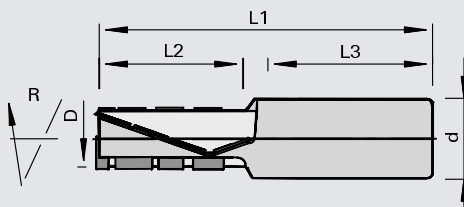
229022

High-Performance Shank-Type Cutters with solid carbide body DP - Z=3

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

- l CNC routers
- l for sizing and dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- l high-performance tool for rough and finish milling, as well as panel sizing with Nesting-Technology
- l with DP plunging tip
- l face cutting for diagonal plunge-cutting
- l feed speeds up to 25 m/min
- l resharpenable area 2.0 mm
- l n max = 24,000 min⁻¹

Advantages

- l high cutting quality and smooth running thanks to spiral design of cutting edges
- l optimum good chip disposal thanks to open arrangement of cutting edges
- l optimum cutting lengths suitable for most popular panel thicknesses

Notes

- l clamping elements: ps-System, Tribos, draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	H	Ident-No.
12	21	16	45	73	3	16-19	181935
12	28	16	45	80	3	22-25	181936
12	30	16	45	82	3	28	181937
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	

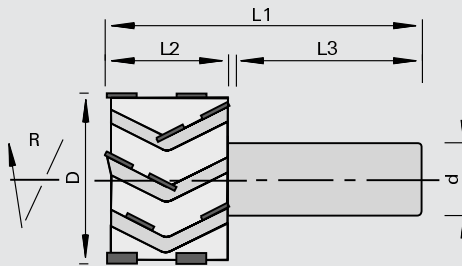
229320

High-Performance Trimming Router Bits DP - Z=4+2+4

Product



Drawing

LEUCO
toplineLEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers
 | for sizing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

| high-performance tool for finish cuts
 | with shear angle
 | resharpener area 3.0 mm

Advantages

| high feed rates (up to 35 m/min) and good edge quality thanks to 4 cutting edges working in top layer
 | minimized formation of dust thanks to 2 cutting edges working in core of board
 | very good surface thanks to large cutting circle diameter
 | good cutting quality on top and bottom edge thanks to opposing shear angle

Notes

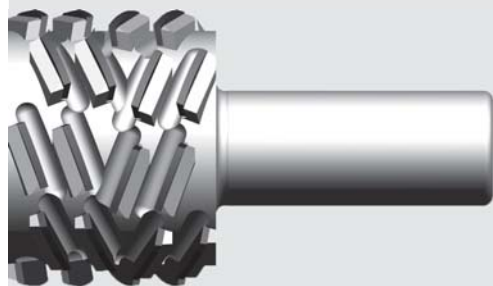
| preferably for finish-cut operations on pre-sized workpieces
 | Clamping elements: ps-System, Tribos, draw-in collet chuck
 | with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	H	Ident-No. [L]	Ident-No. [R]
48	22	25	62	85	4+2+4	16-19	181498 s	181499
48	28	25	62	91	4+2+4	22-25	181500 s	181501
48	35	25	62	98	4+2+4	28-32	181502 s	181503
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

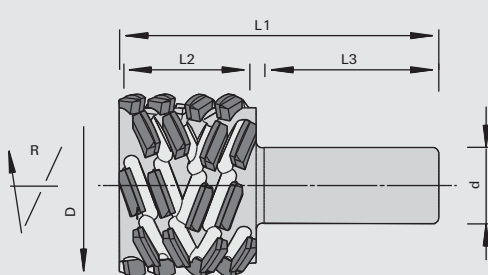
229324

p-System High-Performance Jointing Shank-Type Cutters CM DP

Product



Drawing

LEUCO
topline_{plus}LEUCO
p-system

polycrystalline diamond [DP]

MEC

Machine / Application

- for CNC stationary machines
- for chip-free high-performance jointing of solid woods (free of knots) along and across the grain
- for jointing of melamine-, paper-, HPL-laminated, foiled and veneered panels and lacquered surfaces
- Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- symmetrical and asymmetrical design
- non-convex design
- extremely scoring cut
- resharpening area 4 mm

Advantages

- maximum cutting quality and edge lives
- large depth of cut possible
- chip-free cuts even on the exit side
- perfectly suitable for laser-edge-technology

Notes

- with thread for length adjusting screw
- recommended feed rate per tooth: wood-based panels 0.55 mm, solid wood 0.28 mm
- crowned design on request
- clamping element: precision clamping element e.g. ps-System, Tribos
- sense of rotation according to DIN-EN 50144

Ø D	L2	Ø d	L3	L1	Z	Shear∠		Ident-No. [R]
48	28,2	25	62.2	100	3+3	70	symmetrical	184081
48	38	25	57.4	105	3+3	70	symmetrical	184082
60	38	25	57.4	105	3+3	70	symmetrical	184083 s
60	38	25	57.4	105	4+4	70	symmetrical	184084
60	67,4	25	56.8	135	3+3	70	symmetrical	184080 s
[mm]	[mm]	[mm]	[mm]	[mm]		[°]		

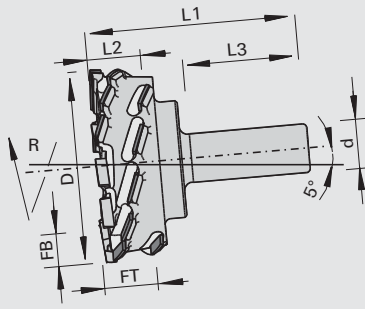
229324

p-System High-Performance Rabbeting Shank-Type Cutter CM DP

Product



Drawing

LEUCO
toplineLEUCO
p-system

polycrystalline diamond [DP]

MEC

Machine / Application

- 5-axis machining centers
- for chip-free high-performance rabbeting of solid woods (free of knots) along and across the grain
- for high-performance rabbeting of melamine-, paper-, HPL-laminated, foiled and veneered panels and lacquered surfaces
- Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- extremely scoring cut
- tool to be used on spindle tilted by 5°
- resharpening area front 2.5 mm, peripheral side 3 mm

Advantages

- maximum cutting quality on both rabbeting sides and maximum edge lives
- chip-free cuts even on the exit side

Notes

- recommended feed rate per tooth: wood-based panels 0.5 - 0.8 mm, solid wood 0.25 - 0.4 mm
- clamping element: precision clamping element e.g. ps-System, Tribos, heat shrink-fit chuck
- with thread for length adjusting screw
- sense of rotation according to DIN-EN 50144

Ø D	L2	Ø d	L3	L1	Z	FB	FT	Shear∠	Ident-No. [R]
100	18,6	25	65	99	3+3	10	15	70	184731
100	28,3	25	65	110	3+3	16	25	70	184732 s
100	43	25	65	120	3+3	16	38	70	184733 s
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[°]	

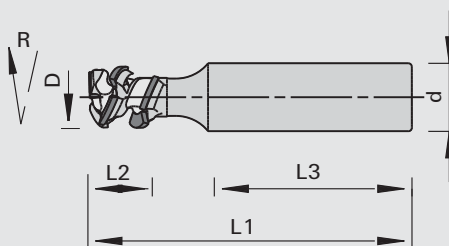
229324

p-System High-Performance Grooving Shank-Type Cutters CM DP

Product



Drawing

LEUCO
topline_{plus}LEUCO
p-system

polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC stationary machines
- | for grooves, cut outs, pockets and as forend cutter
- | for chip-free high-performance grooving of solid woods (free of knots) along and across the grain
- | for high-performance grooving of melamine-, paper-, HPL-laminated, foiled and veneered panels and lacquered surfaces
- | Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- | extremely scoring cut
- | resharpening area front 1.8 mm, peripheral side 2.4 mm

Advantages

- | maximum cutting quality and edge lives
- | chip-free cuts even on the exit side

Notes

- | minimal grooving depth 0.5 mm
- | as from 25 mm Z=2 is possible, bottom cutting edge is Z=1 always
- | convex bottom cutting edge for better bottom quality of rabbet, however corner of rabbet not absolutely sharp
- | for ramping or circular plunging only
- | recommended feed rate per tooth: wood-based panels 0.3 - 0.35 mm, solid wood 0.15 - 0.2 mm
- | clamping element: precision clamping element e.g. ps-System, Tribos, heat shrink-fit chuck
- | with thread for length adjusting screw
- | sense of rotation according to DIN-EN 50144

Ø D	L2	Ø d	L3	L1	Z	Shear◄	Ident-No. [R]
18	7	20	53	90	1+1	70	184772
18	19	20	53	95	1+1	70	184773
25	9	25	51	95	1+1	70	184774 s
25	18	25	51	100	1+1	70	184775 s
[mm]	[mm]	[mm]	[mm]	[mm]		[°]	

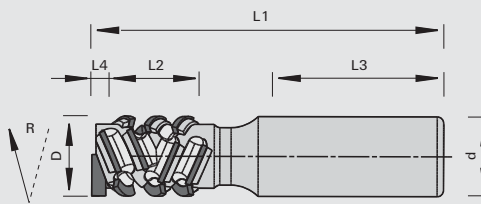
229324

p-System High-Performance Shank-Type Cutters CM DP

Product



Drawing

LEUCO
toplineLEUCO
p-system

polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC stationary machines
- | for chip-free high-performance jointing and dividing of solid woods (free of knots) along and across the grain
- | for jointing and dividing of melamine-, paper-, HPL-laminated, foiled and veneered panels and lacquered surfaces
- | Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- | extremely scoring cut
- | DP plunge tip
- | resharpening area 2.5 mm

Advantages

- | maximum cutting quality and edge lives
- | large depth of cut possible
- | chip-free cuts even on the exit side
- | perfectly suitable for laser-edge-technology

Notes

- | adjust the tool to run centrally to the workpiece
- | Tools with plunge tip must project at least 4,5 mm on bottom side of workpiece in order to bring p-System cutting edges into action. D 30 is without plunge tip
- | for ramping or circular plunging only
- | recommended feed rate per tooth: wood-based panels 0.3 - 0.35 mm, solid wood 0.15 - 0.2 mm
- | clamping element: precision clamping element e.g. ps-System, Tribos
- | with thread for length adjusting screw
- | sense of rotation according to DIN-EN 50144

Ø D	L4	L2	Ø d	L3	L1	Z	H	Shear∠	Ident-No. [R]
20	3.8	25,9	25	55	105	1+1+1	22,9	70	184379
20	3.8	29,5	25	55	110	1+1+1	26,5	70	184380
20	3.8	33,1	25	55	115	1+1+1	30,1	70	184381
25	3.8	26,5	25	55	105	2+2+1	23,5	70	184382
25	3.8	30,8	25	55	110	2+2+1	27,8	70	184383
25	3.8	48,0	25	55	130	2+2+1	45,0	70	184384
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[°]	

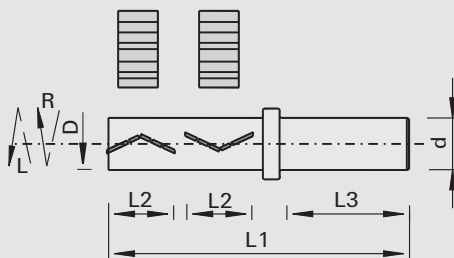
229020

Combination Shank-Type Router Bits RH-LH DP - Z=3/1

Product



Drawing

LEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for sizing and dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels
- | high-performance tool for pre- and finish-milling

Design

- | Z=3 on right hand cutting section for highest feed rates
- | Z=1 on left hand cutting section
- | resharpenable area 3.2 mm

Advantages

- | lower part of the cutter can be run in left hand rotation by adjusting the Z-axis and changing the direction of rotation; this allows optimum machining of frail edges utilizing only one spindle

Notes

- | L2 eff. = L2 eff. = real cutting length; this tool has Z=3 the difference to L2 is Z=2; this allows the machining of all current panel boards
- | workpiece secured on clamping blocks
- | Clamping elements: ps-System, Tribos, draw-in collet chuck
- | with thread for length adjusting screw

Ø D	L2		Ø d	L3	L1	Z	Ident-No.
25	2x22	L2 eff. 19.5 mm	25	62	129	3/1	179497 s
25	2x26	L2 eff. 23.3 mm	25	62	137	3/1	179498 s
25	2x30	L2 eff. 27 mm	25	62	145	3/1	179499
25	2x34	L2 eff. 31 mm	25	62	153	3/1	179500 s
[mm]	[mm]		[mm]	[mm]	[mm]		

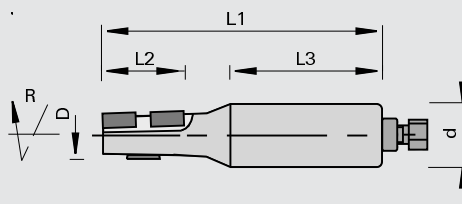
229021

Conical Shank-Type Cutters DP - Z=1+1

Product



Drawing

LEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

- | counter edge banding machines
- | CNC routers
- | for dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- | max. feed speed 30m/min
- | resharpenable area 2.2 mm
- | n max = 18,000 min⁻¹

Advantages

- | high feed speed possible

Notes

- | the finishing of the contour requires further operations
- | Clamping elements: ps-System, Tribos, draw-in collet chuck
- | with thread for length adjusting screw

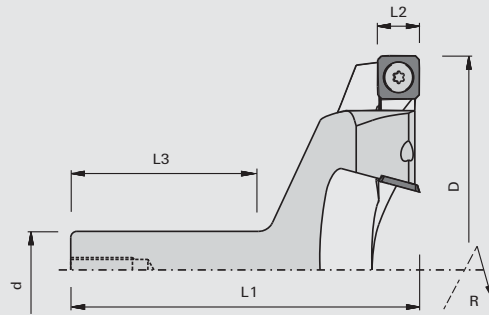
Ø D	L2	Ø d	L3	L1	Z	Tmax	Ident-No. [L]	Ident-No. [R]
18	36	25	65	120	1+1	32	182111 s	179024 s
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

128200

Planing and Rabbeting Shank-Type Cutterheads HW

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

| CNC routers
 | for planing, rabbeting and panel raising in wood-based panels

Design

| cutting material: HL Solid 25

Advantages

| high milling performance when dressing the workbench boards, e.g. with Nesting technology
 | smooth surface thanks to special cutting edge geometry

Notes

| with thread for length adjusting screw
 | sense of rotation according to DIN-EN 50144

Ø D	L2	Ø d	L3	L1	Z	nmax	Ident-No. [R]
100	14	20	45	96	4	15200	182619 s
100	14	25	55	96	4	15200	182620
150	14	25	55	113	4	10100	182621 s
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

Turnover Knives

B

H

S

Class-No.

Ident-No.

14

14

2

150558

182441

[mm]

[mm]

[mm]

Spare parts

Dimension

Class-No.

Ident-No.

Countersunk Flat Headed Screws

M5x6 T20

995125

176199

Screwdrivers

T20x100

985730

166092

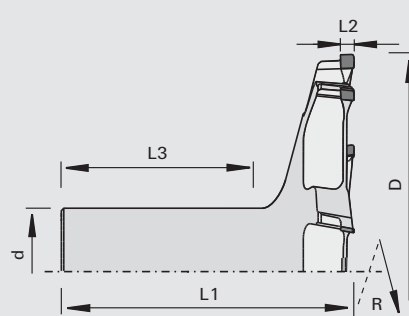
[mm]

229020

Planing and Rabbeting Shank-Type Cutter DP

Product

Drawing

LEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers
 | for planing, rabbeting and panel raising in wood-based panels

Design

| resharpening area 3.5 mm

Advantages

| high milling performance when dressing the workbench boards, e.g. with Nesting technology
 | smooth surface thanks to special cutting edge geometry

Notes

| with thread for length adjusting screw
 | sense of rotation according to DIN-EN 50144

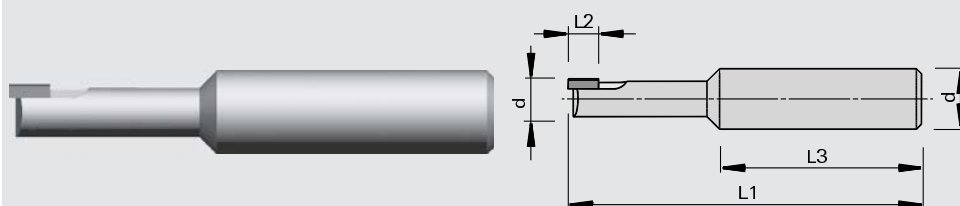
Ø D	L2	Ø d	L3	L1	Z	nmax	Ident-No. [R]
80	5,6	20	61.3	90	6	18000	182660 s
80	5,6	25	62	90	6	24000	182659 s
100	5,6	20	58.6	90	8	18000	182658
100	5,6	25	59.3	90	8	24000	182657 s
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

829720

MONO-DIA Shank-Type Cutters - Z=1

Product

Drawing



Mono Diamond [DM]

MEC

Machine / Application

| CNC machining centers
 | for cutting of transparent, high-gloss surfaces in plexiglass

Design

| without face cutting edge
 | with face cutting edge
 | resharpening area 1,0 mm
 | n max = 24,000 min⁻¹

Advantages

| high edge quality which requires postprocessing in rare cases only

Notes

| Finish milling (removal of 0.1 - 0.2 mm) at a feed rate of approx. 1 m/min
 | the quality can only be reached in connection with a precision clamping element, optimally with Tribos power shrink-fit chuck

Without face cutting edge

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
8	5	12	40	70	1	182522 s
8	6	12	40	70	1	182523
8	8	12	40	70	1	182524 s
20	5	25	55	80	1	182528 s
20	6	25	55	80	1	182529 s
20	8	25	55	80	1	182530 s
[mm]	[mm]	[mm]	[mm]	[mm]		

With face cutting edge

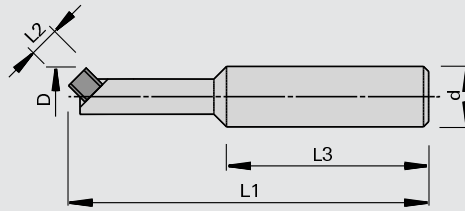
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
8	5	12	40	70	1	182525 s
8	6	12	40	70	1	182526 s
8	8	12	40	70	1	182527 s
20	5	25	55	80	1	182531 s
20	6	25	55	80	1	182532 s
20	8	25	55	80	1	182533 s
[mm]	[mm]	[mm]	[mm]	[mm]		

829730

MONO-DIA Chamfering Cutters - Z=1

Product

Drawing

LEUCO
DIA

Mono Diamond [DM]

MEC

Machine / Application

- | CNC machining centers
- | for cutting of transparent, high-gloss surfaces in plexiglass
- | for milling of chamfers on top- and bottom edge

Design

- | resharpenable area 1.0 mm
- | n max = 24,000 min-1

Advantages

Notes

- | Finish milling (removal of 0.1 - 0.2 mm) at a feed rate of approx. 1 m/min
- | the quality can only be reached in connection with a precision clamping element, optimally with Tribos power shrink-fit chuck

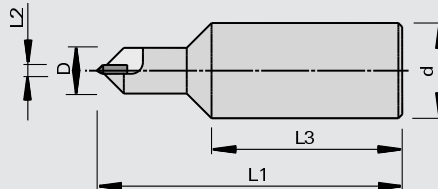
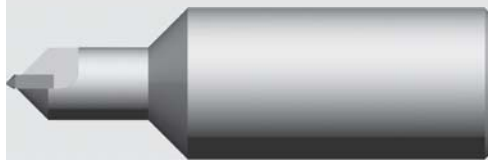
Chamfer	Ø D	L2	Ø d	Z	Ident-No.
45 [°]	16 [mm]	4 [mm]	25 [mm]	1	182535 s

829760

MONO-DIA Engraving Cutters - Z=1

Product

Drawing

LEUCO
DIA

Mono Diamond [DM]

MEC

Machine / Application

- | CNC machining centers
- | for V engravings in plexiglass

Design

- | resharpenable area 0.5 mm
- | n max = 24,000 min-1

Advantages

Notes

- | up to max. 1,5 mm engraving depth

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
12 [mm]	3 [mm]	25 [mm]	50 [mm]	80 [mm]	1	182534 s

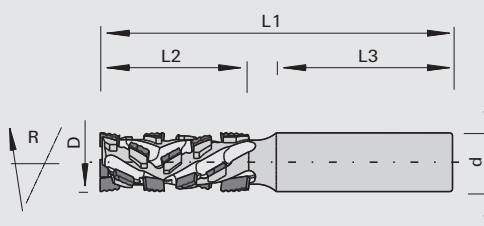
229042

Shank-Type Roughing Cutter DP

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

- for CNC routers
- for sizing in roughing quality with chip-free cutting edges on both sides in solid woods and plywood, laminated wood-based panels or other abrasive materials such as GFK, HPL-compact boards and several sandwich materials
- for cutting of openings and contours
- for traveling plunge cut using Z and X or Y axis

Design

- with alternating shear angle
- with DP plunge tip
- face cutting for diagonal plunge-cutting
- resharpening area ≥ 2.0 mm
- $n_{max} = 30,000 \text{ min}^{-1}$

Advantages

- for long edge lives also in abrasive materials
- chip-free cutting edges on both sides
- high hogging volume

Notes

- slightly rough cutting surface due to fine cut division
- clamping elements: we recommend the use of the tools in high precision clamping chucks such as hydro expansion chucks "ps-System", Tribos or heat shrink-fit chucks

$\emptyset D$	L2	$\emptyset d$	L3	L1	Z	Ident-No. [R]
20	35	20	60	105	2+2	185026
20	50	20	60	120	2+2	185027
[mm]	[mm]	[mm]	[mm]	[mm]		

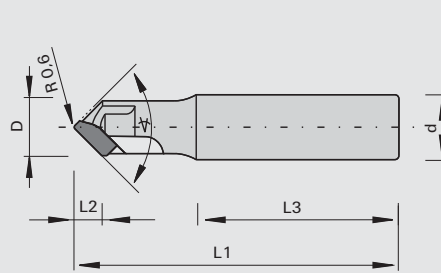
229060

Vektrogramm Cutter DP - 90°

Product



Drawing


 LEUCO
topline

 LEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

| CNC machines
 | for grooving in Vektrogramm-
 technique (Grey-scale millings)

Design

| cutting material: DP
 | Topline design
 | resharping area 2 mm

Advantages

| very long edge lives particularly
 in hard panel materials
 | optimal cutting quality thanks
 to polished face and special
 division of cut

Notes

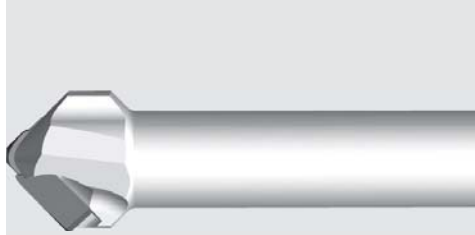
| the Vektrogramm technique is
 a computer-based method to
 transfer image information by
 milling onto board materials

Ø D	L2	L3	Ø d	L1	Z	∠	Ident-No.
14	7	50	16	80	1	90	185 156
[mm]	[mm]	[mm]	[mm]	[mm]		[°]	

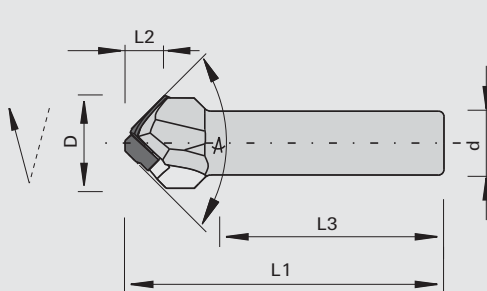
229460

V-Groove Cutter DP for aluminum composite materials

Product



Drawing


 LEUCO
topline

 LEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

| CNC machines
 | for V-grooves in aluminum
 composite materials (Aluco-
 bond, Dibond, etc.)

Design

| cutting material: DP
 | Topline design
 | resharping area 2 mm

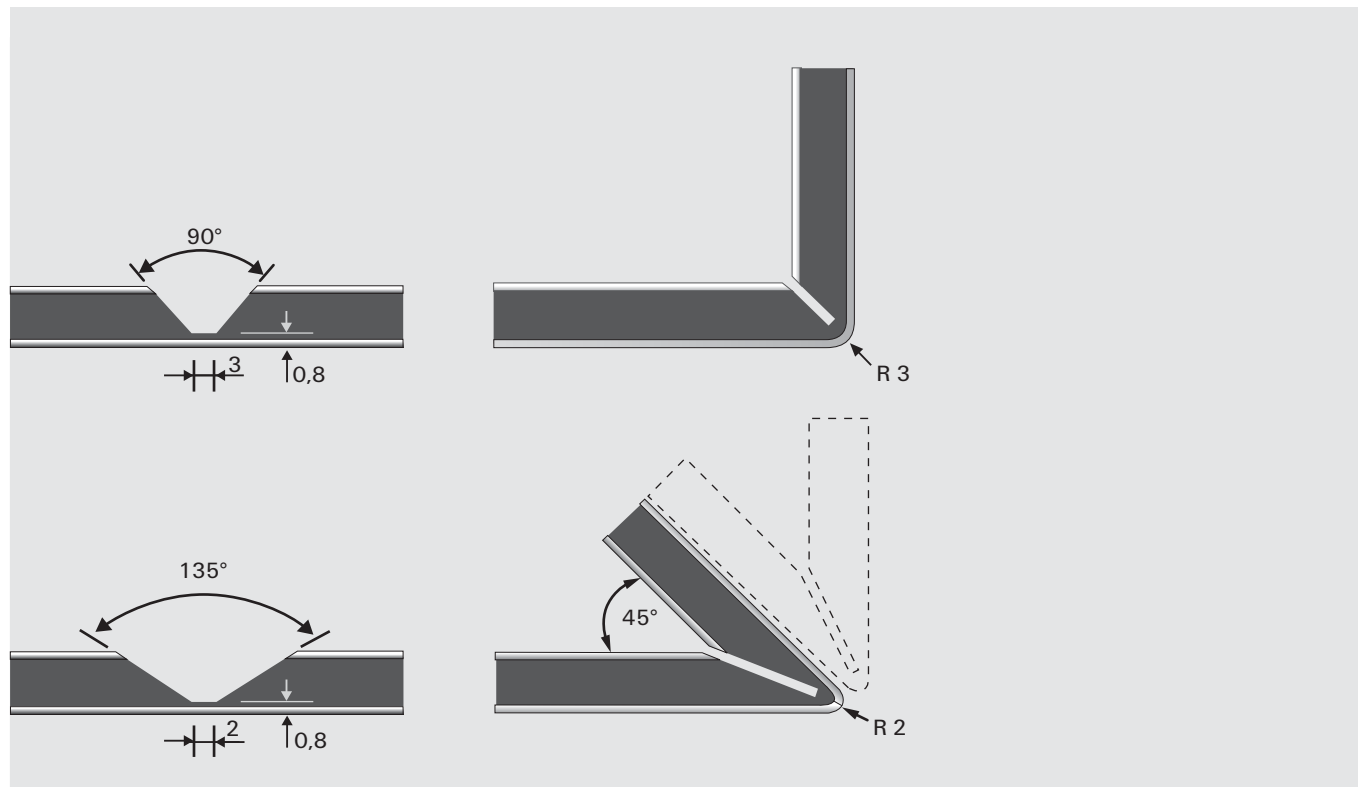
Advantages

| very long edge lives particularly
 in composite materials with
 mineral core
 | optimal cutting quality thanks
 to polished face and special
 division of cut

Notes

| clamping elements: ideal
 use in precision clamping
 elements e.g. ps-System,
 Tribos or heat-shrinking chuck

Ø D	L2	L3	Ø d	L1	Z	∠	Ident-No.
18	7,5	40	12	60	1+1	90	185025
32	6,2	40	12	60	1+1	135	185 196
[mm]	[mm]	[mm]	[mm]	[mm]		[°]	



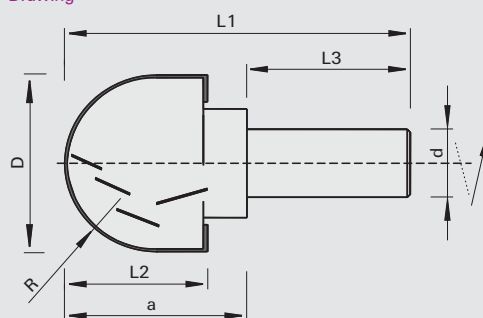
128660

Spherical Cutterhead HW

Product



Drawing



LEUCO
CNC

tungsten carbide [HW]

MEC

Machine / Application

- l CNC 5-axis routers
- l for milling shapes and contours in solid wood and wood-based panels
- l ideal for forms

Design

- l with shank
- l n max = 15,000 min⁻¹

Advantages

- l high volume to be removed
- l simple tool change

Notes

- l ideal for the basic equipment of a 5-axis machine
- l please order adapters separately
- l clamping elements: ps-System, Tribos, heat-shrinking chuck, draw-in collet chucks
- l NEW, extra long tool adapters

R	Ø D	L2	Ø d	L3	L1	Z	a	Ident-No.
32,5	65	52	25	60	127	2+2	67	185082
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	

Turnover Knives	B	H	S	R	Class-No.	Ident-No.
	20	12	1.5		150515	003082
	20	11.5	1.5	30,7	151521	185083
	[mm]	[mm]	[mm]	[mm]		

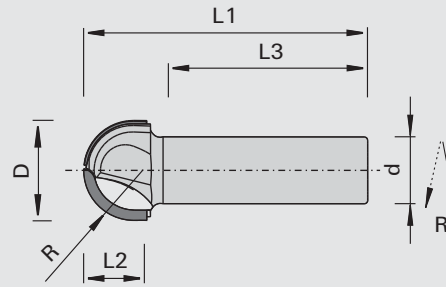
Spare parts	Dimension	Class-No.	Ident-No.
Screwdrivers	T15x80	985730	171188
Screwdrivers	SW3x100	985730	166090
	[mm]		

229560

DIAMAX PCD Bull-Nose Shank-Type Cutter

Product

Drawing


 LEUCO
topline

 LEUCO
DIAMAX

polycrystalline diamond [DP]

MEC

Machine / Application

| CNC machines
 | for contour milling and
 template copying
 | for 3D-milling work, 3D-models,
 relief-milling work

Design

| TOPLINE design
 | resharping area 1.5 mm
 | n max = 24,000 min-1

Advantages

| long edge lives
 | high quality of cut thanks to
 polished cutting edges and
 ultra-fine eroding of back of the
 tooth

Notes

| clamping elements: we
 recommend the use of
 the tools in high precision
 clamping chucks such as
 hydro expansion chucks
 "ps-System", Tribos or heat
 shrink-fit chucks

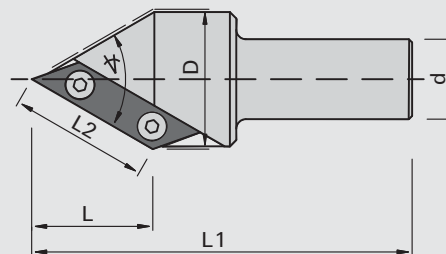
R	Ø D	L2	Ø d	L3	L1	Z	Ident-No.
10	20	14	20	55	85	2	185240
15	30	19	20	55	85	2	185241
20	40	24	20	55	85	2	185242
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

128410

Folding Chamfering Cutterheads HW - Z1

Product

Drawing


 LEUCO
CNC

tungsten carbide [HW]

MEC

Machine / Application

| CNC 5-axis routers
 | for picking of internal corners
 and for chamfering, for the
 cutting of ornamental grooves
 and folding cuts in solid wood
 and wood-based panels

Design

| with shank
 | n max = 15,000 min-1

Advantages

Notes

| please order adapters
 separately
 | clamping elements: ps-
 System, Tribos, heat-shrinking
 chuck, draw-in collet chucks

Wedge<	Ø D	L2	L	Ø d	L1	Z	Ident-No.
60	41.5	41,5	35.5	25	118	1	185138
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives

B

H

S

Class-No.

Ident-No.

50

12

1.5

150515

185140

[mm]

[mm]

[mm]

Spare parts

Dimension

Class-No.

Ident-No.

Round Head Screws

M3,5x4 T15

995195

168893

Screwdrivers

T15

985730

163161

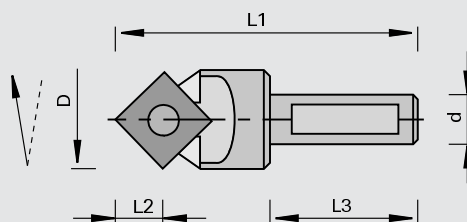
[mm]

128415

Ornamental Groove Cutters with HW TOK

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

- portable routers
- CNC routers
- for cutting of ornamental grooves, inscriptions and engravings in solid woods and wood-based panels

Design

- with negative shear angle

Advantages

- combination with other shank-type tools allows 2 processes on one spindle
- chip-free cutting of laminated panels thanks to negative shear angle

Notes

- clamping elements: ps-System with reducing sleeves Class-No. 933280, draw-in collet chuck for combination with cutterheads as tool set
- included in delivery: Ident-No. 171169 SP16 cutter assembly with TOK Ident-No. 003080 or set Ident-No. 171217 see profile drawings

Ø D	L2	Ø d	L3	L1	Z	Drawing	Ident-No.
17	8,3	10	21	48	1	SP 16	171169
						Set	171217 &
[mm]	[mm]	[mm]	[mm]	[mm]		[Foil]	

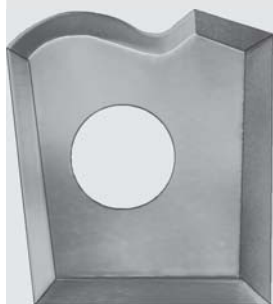
Turnover Knives	B	H	S	Drawing/Foil	Class-No.	Ident-No.
	12	12	1.5	SP 16	150515	003080
	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	Ident-No.
Head Cap Screws	M3,5x6,5 T15	995115	163223
Screwdrivers	T15	985730	163161
	[mm]		

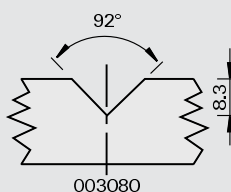
150514 / 151521

Profile Knives HW for ornamental groove cutterheads

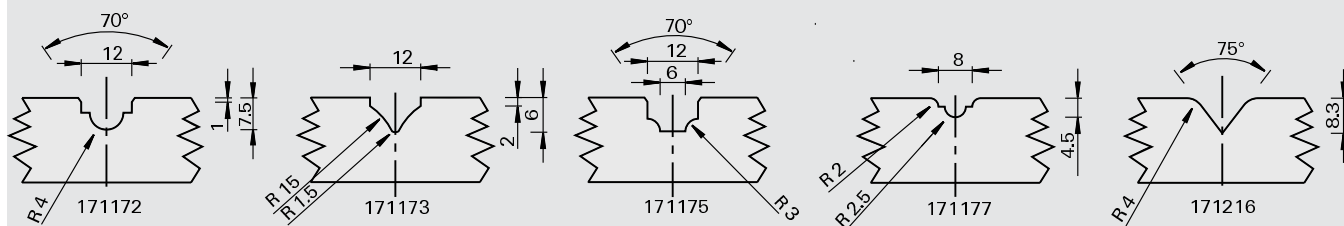
Product



Drawing



tungsten carbide [HW]



Machine / Application

Design

Advantages

Notes

I included in delivery of set
 Ident-No. 171217: 1 piece
 ornamental groove cutter with
 shank (Ident-No. 171169)
 / 1 piece turnover
 knife 12x12x1.5 (Ident-
 No. 003080) / 2 pieces each
 double-sided profile knives
 Class-No. 151521 (Ident- No.
 and drawing as shown)

B	H	S	Drawing	Ident-No.
12	12	1.5	SP 16	003080
11	12	1.5		171172
11	12	1.5		171173
11	12	1.5		171175 #
12	12	1.5		171177 #
12	12	1.5		171216
[mm]	[mm]	[mm]	[Foil]	

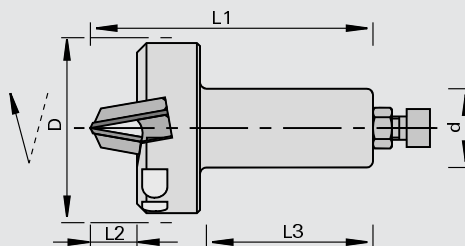
128612

Ornamental Groove SuperProfiler Shank-Type Cutterheads HW

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

- l CNC routers
- l for cutting of ornamental grooves in solid woods and wood-based panels

Design

- l with positive shear angle
- l cutting material: HW HL Board 06 for hard woods and wood-based panels
- l cutting material: HW HL Solid 60 for soft woods
- l n max = 18,000 min⁻¹

Advantages

- l cutterhead for mounting of several profile knives

Notes

- l profile knife can be profiled according to customer specifications
- l Clamping elements: ps-System, Tribos, draw-in collet chuck
- l included in delivery: cutterhead body with clamping elements without profile knives and support plates

Ø D	L2	Ø d	L3	L1	Z	Drawing	Ident-No. unprofiled
59	13	25	62	97	2	SP 17	173268
[mm]	[mm]	[mm]	[mm]	[mm]		[Foil]	

Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	Ident-No.
SP blanks	30,6	25.5	HL Board 06	SP 17	152526	179114
SP blanks	30,6	25.5	HL Solid 60	SP 17	152529	177369
support plates				SP 17	925402	178017
	[mm]	[mm]				

Spare parts	Dimension	Class-No.	Ident-No.
Clamping Bars	B=24	925300	173276
Set Screws	M6x10 DIN EN ISO 4028	995161	180002
Screwdrivers	SW3x100	985730	166090
	[mm]		

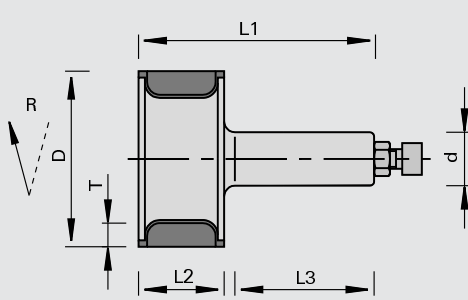
128612

SuperProfiler Shank-Type Cutterheads HW

Product



Drawing


**SUPER
PROFILER**

tungsten carbide [HW]

MEC

Machine / Application

- CNC routers
- for profiling of solid woods and wood materials

Design

- cutting edges parallel to cutter axis
- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods

Advantages

- cutterhead for mounting of several profile knives

Notes

- profile knife can be profiled according to customer specifications
- Clamping elements: ps-System, Tribos, draw-in collet chuck
- included in delivery: cutterhead body with clamping elements without profile knives and support plates

Ø D	L2	Ø d	L3	L1	Tmax	Z	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
82	40	20	55	110	11	2	12000	SP 19		167479
82	40	25	55	110	11	2	18000	SP 19	167835 s	167834
82	40	MK 2	55	127	11	2	18000	SP 19		167483 s
86	60	25	55	130	13	2	10000	SP 31		176241
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]		

Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	Ident-No.
SP blanks	40,6	28,2	HL Board 06	SP 19	152526	179112
SP blanks	40,6	28,2	HL Solid 60	SP 19	152529	177367
SP blanks	60,8	30,2	HL Board 06	SP 31	152526	179113
SP blanks	60,8	30,2	HL Solid 60	SP 31	152529	177368
support plates	40	28		SP 19	925402	178007
support plates	60	30		SP 31	925402	178008
	[mm]	[mm]				

Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Clamping Bars	36x12x8	167835	925300	166736
Clamping Bars	36x12x8	167483, 167834, 167479	925300	166737
Clamping Bars	58x12x8	176241	925300	166738
Set Screws	M8x16 DIN EN ISO 4028		995161	164422
Screwdrivers	SW4x100		985730	166091
	[mm]			

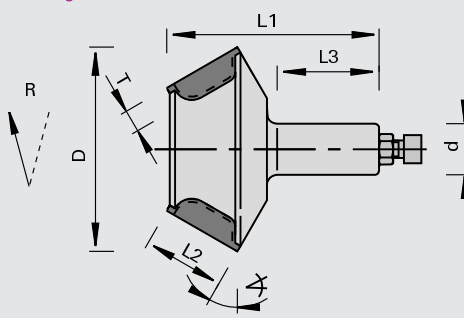
128612

SuperProfiler Shank-Type Cutterheads HW - cranked

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

- l CNC routers
- l for profiling of solid woods and wood materials

Design

- l cranked body
- l cutting edges parallel to cutter axis
- l cutting material: HW HL Board 06 for hard woods and wood-based panels
- l cutting material: HW HL Solid 60 for soft woods
- l Ø 100 mm and 110 mm: n max = 12,000 min-1
- l Ø 125 mm: n max = 8,000 min-1

Advantages

- l for deep profiles

Notes

- l profile knife can be profiled according to customer specifications
- l Clamping elements: ps-System, Tribos, draw-in collet chuck
- l included in delivery: cutter-head body with clamping elements without profile knives and support plates

Ø D	L2	Ø d	L3	L1	Tmax	Z	Drawing	Ident-No. unprofiled
100	40	25	55	119	11	2	SP 18	168184 s
110	40	25	55	120	11	2	SP 27	176235 s
125	60	25	55	140	13	2	SP 28	176237 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[Foil]	

Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	Ident-No.
SP blanks	40,6	28.2	HL Board 06	SP 18 / 27	152526	179112
SP blanks	40,6	28.2	HL Solid 60	SP 18 / 27	152529	177367
SP blanks	60,8	30.2	HL Board 06	SP 28	152526	179113
SP blanks	60,8	30.2	HL Solid 60	SP 28	152529	177368
support plates	40	28		SP 18 / 27	925402	178007
support plates	60	30		SP 28	925402	178008
	[mm]	[mm]				

Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Clamping Bars	36x12x8	176235, 168184	925300	166737
Clamping Bars	58x12x8	176237	925300	166738
Set Screws	M8x16 DIN EN ISO 4028		995161	164422
Screwdrivers	SW4x100		985730	166091
	[mm]			

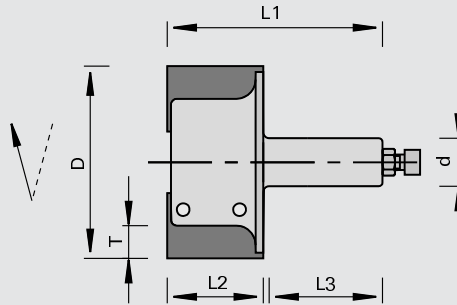
128612

SuperProfiler Shank-Type Cutterheads HW - open on one side

Product



Drawing


**SUPER
PROFILER**

tungsten carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for profiling of solid woods and wood materials

Design

- | cutting edges parallel to cutter axis
- | cutting material: HW HL Board 06 for hard woods and wood-based panels
- | cutting material: HW HL Solid 60 for soft woods

Advantages

- | cutterhead for mounting of several profile knives

Notes

- | for profiles requiring a cutter body which is open on one side
- | profile knife can be profiled according to customer specifications
- | Clamping elements: ps-System, Tribos, draw-in collet chuck
- | included in delivery: cutter-head body with clamping elements without profile knives and support plates

Ø D	L2	Ø d	L3	L1	Tmax	Z	nmax	Drawing	Ident-No. [R] unprofiled
60	30	16	43	89.6	11	2	12000	SP 23	171033
100	50	25	55	112	16	2	9500	SP 21	171143
120	50	25	55	109	22	2	6500	SP 20	173271
120	60	25	55	118	22	2	6000	SP 22	173270
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]	

Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	Ident-No.
SP blanks	30,6	25.5	HL Board 06	SP 23	152526	179114
SP blanks	30,6	25.5	HL Solid 60	SP 23	152529	177369
SP blanks	49,3	33.7	HL Board 06	SP 21	152526	180199
SP blanks	49,4	44.5	HL Board 06	SP 20	152526	180218
SP blanks	60,6	45.6	HL Board 06	SP 22	152526	179999
SP blanks	60,6	45.6	HL Solid 60	SP 22	152529	178845
support plates	30	25		SP 23	925402	178016
support plates	50	34		SP 21	925402	178015
support plates	50	45		SP 20	925402	178014
support plates	60	45		SP 22	925402	178010
	[mm]	[mm]				

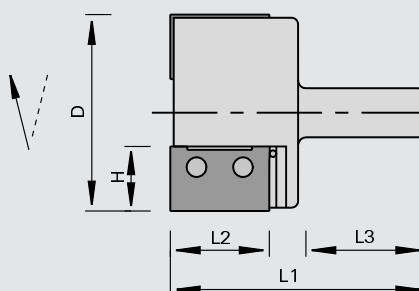
Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Clamping Bars	28x10x7	171033	925300	171035
Clamping Bars	48x12x8	171143	925300	171147
Clamping Bars	47x14x8	173271	925300	171140
Clamping Bars	56x12x8	173270	925300	167055
Set Screws	M6x10 DIN EN ISO 4028	171033	995161	180002
Set Screws	M8x16 DIN EN ISO 4028	171143, 173270, 173271	995161	164422
Screwdrivers	SW3x100	171033	985730	166090
Screwdrivers	SW4x100	171143, 173270, 173271	985730	166091
	[mm]			

128613

EcoPro-Shank-Type Cutterheads HW

Product

Drawing



tungsten carbide [HW]

MEC

Machine / Application

| CNC routers
 | for profiling of solid woods and wood-based panels

Design

| cutting material: HW HL Board 06 for hard woods and wood-based panels
 | cutting material: HW HL Solid 60 for soft woods
 | shank with internal thread M8 for attachment screw

Advantages

| cutterhead body and knives will be profiled according to customer specifications

Notes

| profile knives can be profiled according to customer specifications
 | cutterhead body can be used only for one profile
 | please order stop screw separately

Ø D	L2	H	Ø d	L3	L1	Z	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
62	30	25	25	60	107	2	18000	EP 375	178594 s	178375 s
75	30	30	25	60	107	2	16000	EP 376	178597 s	178376 s
62	40	20	25	60	117	2	18000	EP 377	178592 s	178377 s
75	40	30	25	60	117	2	14000	EP 378	178598 s	178378 s
62	50	20	25	60	127	2	16000	EP 379	178593 s	178379 s
75	50	33	25	60	127	2	12000	EP 380	178600 s	178380 s
85	50	33	25	60	127	2	12000	EP 386	178603 s	178386 s
75	40	32.5	25	60	118	2	12300	EP 478	180332 s	180328 s
85	60	34	25	60	137	2	10000	EP 405	181247 s	181246 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]		

Blanks for Ident-No.	B	H	LEUCODUR	Class-No.	Ident-No. [L]	Ident-No. [R]
178375, 178594	30,2	25.5	HL Board 06	152586		178527
178375, 178594	30,2	25.5	HL Solid 60	152589		179527
178376, 178597	30,2	30.4	HL Board 06	152586		178528
178376, 178597	30,2	30.4	HL Solid 60	152589		179528
178377, 178592	40,1	20.9	HL Board 06	152586		178533
178377, 178592	40,1	20.9	HL Solid 60	152589		179533
180328, 180332	41	32.5	HL Board 06	152536		180197
178378, 178598	40,1	30.4	HL Board 06	152586		178534
178378, 178598	40,1	30.4	HL Solid 60	152589		179534
178379, 178593	49,9	20.9	HL Board 06	152586		178539
178379, 178593	49,9	20.9	HL Solid 60	152589		179539
178380, 178386, 178600, 178603	49,9	33	HL Board 06	152586		178540
178380, 178386, 178600, 178603	49,9	33	HL Solid 60	152589		179540
181246, 181247	61	34	HL Board 06	152536		180198
178375, 178594	30,2	25.5	HL Board 06 Topline	152786	179583 &	179584 &
178375, 178594	30,2	25.5	HL Solid 60 Topline	152789	179657 &	179658 &
178376, 178597	30,2	30.4	HL Board 06 Topline	152786	179585 &	179586 &
178376, 178597	30,2	30.4	HL Solid 60 Topline	152789	179659 &	179660 &
178377, 178592	40,1	20.9	HL Board 06 Topline	152786	179595 &	179596 &
178377, 178592	40,1	20.9	HL Solid 60 Topline	152789	179669 &	179670 &
178378, 178598	40,1	30.4	HL Board 06 Topline	152786	179597 &	179598 &
178378, 178598	40,1	30.4	HL Solid 60 Topline	152789	179671 &	179672 &
178379, 178593	49,9	20.9	HL Board 06 Topline	152786	179607 &	179608 &
178379, 178593	49,9	20.9	HL Solid 60 Topline	152789	179681 &	179682 &
178380, 178386, 178600, 178603	49,9	33	HL Board 06 Topline	152786	179609 &	179610 &
	[mm]	[mm]				

Blanks for Ident-No.	B	H	LEUCODUR	Class-No.	Ident-No. [L]	Ident-No. [R]
178380, 178386, 178600, 178603	49,9	33	HL Solid 60 Topline	152789	179683 &	179684 &
181246, 181247	61	34	HL Board 06 Topline	152736	181259	181258
	[mm]	[mm]				
Spare parts			Dimension	Class-No.	Ident-No.	
Screws			M4,5x4,6x9 T15	995195	178239	
Screwdrivers			T15x80	985730	171188	
			[mm]			

128663

EcoPro-Shank-Type Cutterheads HW - cranked

Product	Drawing	
		tungsten carbide [HW] MEC

Machine / Application	Design	Advantages	Notes
- CNC routers - for profiling of solid woods and wood-based panels	- with shear angle - cutting material: HW HL Board 06 for hard woods and wood-based panels - cutting material: HW HL Solid 60 for soft woods - shank with internal thread M8 for attachment screw	- optimum cutting quality even when cutting across the grain of solid woods thanks to shear angle - cutterhead body and knives will be profiled according to customer specifications	- profile knives can be profiled according to customer specifications - cutterhead body can be used only for one profile - please order stop screw separately

Crank-°	Ø D	L2	H	L1	Z	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
60	100	30	25	104	2	11000	EP 387	178604 s	178387 s
60	100	30	30	107	2	9500	EP 388	178606 s	178388 s
60	100	40	20	110	2	13000	EP 389	178605 s	178389 s
60	100	50	20	119	2	11000	EP 391	178607 s	178391 s
60	125	50	33	127	2	7500	EP 392	178609 s	178392 s
45	100	30	25	104	2	10000	EP 393	178610 s	178393 s
45	100	30	30	107	2	9000	EP 394	178611 s	178394 s
45	100	40	20	110	2	13000	EP 395	178612 s	178395 s
45	125	50	20	114	2	10000	EP 397	178614 s	178397 s
45	125	50	33	121	2	7500	EP 398	178615 s	178398 s
45	125	40	32.5	115	2	11000	EP 496	180335 s	180331 s
45	145	60	34	132	2	10000	EP 408	181251 s	181250 s
60	145	60	34	137	2	10000	EP 407	181253 s	181252 s
75	125	60	34	133	2	10000	EP 406	181255 s	181254 s
[°]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]		

Blanks for Ident-No.	B	H	LEUCODUR	Class-No.	Ident-No. [L]	Ident-No. [R]
178387, 178393, 178604, 178610	30,2	25.5	HL Board 06	152586		178527
178387, 178393, 178604, 178610	30,2	25.5	HL Solid 60	152589		179527
178388, 178394, 178606, 178611	30,2	30.4	HL Board 06	152586		178528
178388, 178394, 178606, 178611	30,2	30.4	HL Solid 60	152589		179528
178389, 178395, 178605, 178612	40,1	20.9	HL Board 06	152586		178533
	[mm]	[mm]				

Profiled Shank-Type Tools for stationary routers

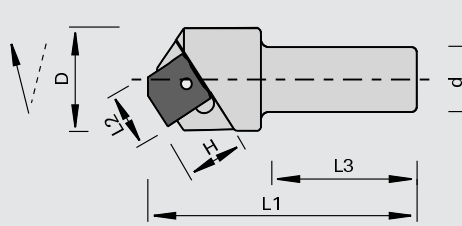
Blanks for Ident-No.	B	H	LEUCODUR	Class-No.	Ident-No. [L]	Ident-No. [R]
178389, 178395, 178605, 178612	40,1	20.9	HL Solid 60	152589		179533
180331, 180335	41	32.5	HL Board 06	152536		180197
178391, 178397, 178607, 178614	49,9	20.9	HL Board 06	152586		178539
178391, 178397, 178607, 178614	49,9	20.9	HL Solid 60	152589		179539
178392, 178398, 178609, 178615	49,9	33	HL Board 06	152586		178540
178392, 178398, 178609, 178615	49,9	33	HL Solid 60	152589		179540
181250, 181251, 181252, 181253, 181254, 181255	61	34	HL Board 06	152536		180198
178387, 178393, 178604, 178610	30,2	25.5	HL Board 06 Topline	152786	179583 &	179584 &
178387, 178393, 178604, 178610	30,2	25.5	HL Solid 60 Topline	152789	179657 &	179658 &
178388, 178394, 178606, 178611	30,2	30.4	HL Board 06 Topline	152786	179585 &	179586 &
178388, 178394, 178606, 178611	30,2	30.4	HL Solid 60 Topline	152789	179659 &	179660 &
178389, 178395, 178605, 178612	40,1	20.9	HL Board 06 Topline	152786	179595 &	179596 &
178389, 178395, 178605, 178612	40,1	20.9	HL Solid 60 Topline	152789	179669 &	179670 &
178391, 178397, 178607, 178614	49,9	20.9	HL Board 06 Topline	152786	179607 &	179608 &
178391, 178397, 178607, 178614	49,9	20.9	HL Solid 60 Topline	152789	179681 &	179682 &
178392, 178398, 178609, 178615	49,9	33	HL Board 06 Topline	152786	179609 &	179610 &
178392, 178398, 178609, 178615	49,9	33	HL Solid 60 Topline	152789	179683 &	179684 &
181250, 181251, 181252, 181253, 181254, 181255	61	34	HL Board 06 Topline	152736	181259	181258
	[mm]	[mm]				
Spare parts			Dimension	Class-No.	Ident-No.	
Screws			M4,5x4,6x9 T15	995195	178239	
Screwdrivers			T15x80	985730	171188	
			[mm]			

128663

EcoPro-Shank-Type Cutterheads HW for ornamental grooves - Z1

Product

Drawing



tungsten carbide [HW]

MEC

Machine / Application

| CNC routers
 | for cutting of ornamental
 grooves in solid woods and
 wood-based panels

Design

| cutting material: HW HL
 Board 06 for hard woods and
 wood-based panels
 | cutting material: HW HL Solid
 60 for soft woods
 | shank with internal thread M8
 for attachment screw
 | with shear angle

Advantages

| optimum cutting quality even
 when cutting across the grain
 of solid woods thanks to shear
 angle
 | cutterhead body and knives
 will be profiled according to
 customer specifications

Notes

| profile knives can be profiled
 according to customer
 specifications
 | cutterhead body can be used
 only for one profile
 | please order stop screw
 separately

Ø D	L2	H	Ø d	L3	L1	Z	nmax	Drawing	Ident-No. [R] unprofild
35	20	20	25	60	98.5	1	24000	EP 400	180539 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]	

Blanks for Ident-No.	B	H	LEUCODUR	Class-No.	Ident-No. [L]	Ident-No. [R]
	20,3	20.5	HL Board 06	152586		178517
	20,3	20.5	HL Solid 60	152589		179517
	20,3	20.5	HL Board 06 Topline	152786	179563 &	179564 &
	20,3	20.5	HL Solid 60 Topline	152789	179637 &	179638 &
	[mm]	[mm]				

Spare parts

Dimension

Class-No.

Ident-No.

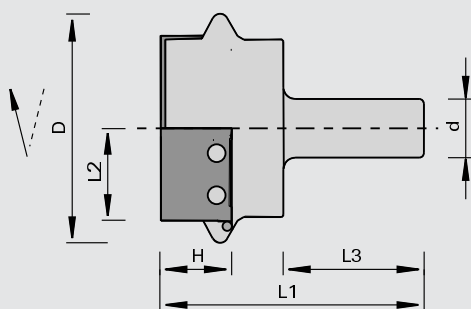
Screws	M4,5x4,6x9 T15	995195	178239
Screwdrivers	T15x80	985730	171188
	[mm]		

128663

EcoPro-Shank-Type Cutterheads HW for large ornamental grooves - Z2

Product

Drawing



tungsten carbide [HW]

MEC

Machine / Application

| CNC routers
 | for cutting of big ornamental grooves in solid woods and wood-based panels

Design

| cutting material: HW HL Board 06 for hard woods and wood-based panels
 | cutting material: HW HL Solid 60 for soft woods
 | shank with internal thread M8 for attachment screw
 | with shear angle

Advantages

| optimum cutting quality even when cutting across the grain of solid woods thanks to shear angle
 | cutterhead body and knives will be profiled according to customer specifications

Notes

| profile knives can be profiled according to customer specifications
 | cutterhead body can be used only for one profile
 | please order stop screw separately

Ø D	L2	H	Ø d	L3	L1	Z	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
76	30	25	25	60	101	2	18000	EP 401	180298 s	180299 s
76	30	30	25	60	109	2	18000	EP 403	180296 s	180297 s
100	40	30	25	60	112	2	14000	EP 402	178401 s	178402 s
120	50	33	25	60	122	2	9000	EP 404	178403 s	178404 s
143	60	34	25	60	122	2	12000	EP 409	181257 s	181256 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]		

Blanks for Ident-No.	B	H	LEUCODUR	Class-No.	Ident-No. [L]	Ident-No. [R]
180298, 180299	30,2	25,5	HL Board 06	152586		178527
180298, 180299	30,2	25,5	HL Solid 60	152589		179527
180296, 180297	30,2	30,4	HL Solid 60	152589		179528
180296, 180297	30,2	30,4	HL Board 06	152586		178528
178401, 178402	40,1	30,4	HL Board 06	152586		178534
178401, 178402	40,1	30,4	HL Solid 60	152589		179534
178403, 178404	49,9	33	HL Board 06	152586		178540
178403, 178404	49,9	33	HL Solid 60	152589		179540
181256, 181257	61	34	HL Board 06	152536		180198
180298, 180299	30,2	25,5	HL Board 06 Topline	152786	179583 &	179584 &
180298, 180299	30,2	25,5	HL Solid 60 Topline	152789	179657 &	179658 &
180296, 180297	30,2	30,4	HL Board 06 Topline	152786	179585 &	179586 &
180296, 180297	30,2	30,4	HL Solid 60 Topline	152789	179659 &	179660 &
178401, 178402	40,1	30,4	HL Board 06 Topline	152786	179597 &	179598 &
178401, 178402	40,1	30,4	HL Solid 60 Topline	152789	179671 &	179672 &
178403, 178404	49,9	33	HL Board 06 Topline	152786	179609 &	179610 &
178403, 178404	49,9	33	HL Solid 60 Topline	152789	179683 &	179684 &
181256, 181257	61	34	HL Board 06 Topline	152736	181259	181258
	[mm]	[mm]				

Spare parts

Dimension

Class-No.

Ident-No.

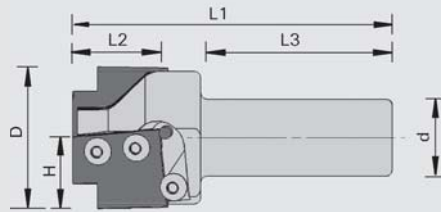
Screws	M4,5x4,6x9 T15	995195	178239
Screwdrivers	T15x80	985730	171188
	[mm]		

128663

EcoPro-Shank-Type Cutterheads HW - Z2

Product

Drawing


 LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

| CNC routers
 | for cutting of ornamental
 grooves in solid woods and
 wood-based panels

Design

| cutting material: HW HL
 Board 06 for hard woods and
 wood-based panels
 | cutting material: HW HL Solid
 60 for soft woods
 | shank with internal thread M8
 for attachment screw

Advantages

| cutterhead body and knives
 will be profiled according to
 customer specifications
 | inserts cutting beyond center

Notes

| profile knives can be profiled
 according to customer
 specifications
 | cutterhead body can be used
 only for one profile
 | please order stop screw
 separately

Ø D	L2	H	Ø d	L3	L1	Z	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
44	28	25	25	60	103.5	2	24000	EP 399	181839 s	181838 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]		

Blanks	B	H	LEUCODUR	Class-No.	Ident-No. [L]	Ident-No. [R]
	30,2	25.5	HL Board 06	152586		178527
	30,2	25.5	HL Solid 60	152589		179527
	30,2	25.5	HL Board 06 Topline	152786	179583 &	179584 &
	30,2	25.5	HL Solid 60 Topline	152789	179657 &	179658 &
	[mm]	[mm]				

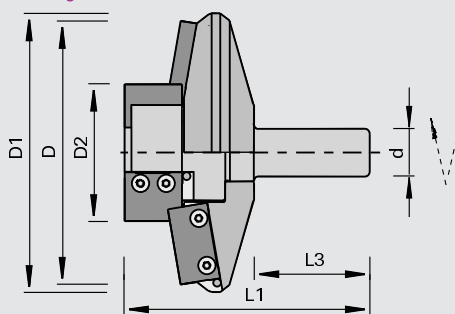
Spare parts	Dimension	Class-No.	Ident-No.
Round Head Screws	M4x5,9 T15	995195	167966
Screwdrivers	T15x80	985730	171188
	[mm]		

128913

EcoPro-Shank-Type Cutterheads HW for panel raising top side

Product

Drawing



tungsten carbide [HW]

MEC

Machine / Application

| CNC routers
 | for profiling of solid woods and wood-based panels

Design

| cutting material: HW HL Board 06 for hard woods and wood-based panels
 | cutting material: HW HL Solid 60 for soft woods
 | shank with internal thread M8 for attachment screw

Advantages

| optimum cutting quality even when cutting across the grain of solid woods
 | for panel raising profiles
 | cutterhead body and knives will be profiled according to customer specifications

Notes

| profile knives can be profiled according to customer specifications
 | cutterhead body can be used only for one profile
 | please order stop screw separately

Ø D	Ø D1	Ø D2	Ø d	L3	L1	Z	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
150	140	82	25	60	122	2+2	7600	EP 751 (EP 754+757)	179369 s	178751 s
137	145	71.6	25	60	122	2+2	11500	EP 752 (EP 755+758)	179370 s	178752 s
137	145	71.2	25	60	127	2+2	11500	EP 753 (EP 756+758)	179371 s	178753 s
142	144	82	25	60	123	2+2	10000	EP 849 (EP 754+855)	179372 s	178849 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]		

Blanks for Ident-No.	B	H	LEUCODUR	Class-No.	Ident-No. [L]	Ident-No. [R]
178753, 179371	30,2	25.5	HL Board 06	152586		178527
178753, 179371	30,2	25.5	HL Solid 60	152589		179527
178751, 178752, 178849, 179369, 179370	30,2	30.4	HL Board 06	152586		178528
178751, 178752, 178849, 179369, 179370	30,2	30.4	HL Solid 60	152589		179528
178752, 178753, 179370, 179371	40,1	20.9	HL Board 06	152586		178533
178752, 178753, 179370, 179371	40,1	20.9	HL Solid 60	152589		179533
178751, 179369	40,1	30.4	HL Board 06	152586		178534
178751, 179369	40,1	30.4	HL Solid 60	152589		179534
178849, 179372	49,9	20.9	HL Board 06	152586		178539
178849, 179372	49,9	20.9	HL Solid 60	152589		179539
178753	30,2	25.5	HL Board 06 Topline	152786	179583 &	179584 &
178753	30,2	25.5	HL Solid 60 Topline	152789	179657 &	179658 &
178751, 178752, 178849	30,2	30.4	HL Board 06 Topline	152786	179585 &	179586 &
178751, 178752, 178849	30,2	30.4	HL Solid 60 Topline	152789	179659 &	179660 &
178752, 178753	40,1	20.9	HL Board 06 Topline	152786	179595 &	179596 &
178752, 178753	40,1	20.9	HL Solid 60 Topline	152789	179669 &	179670 &
178751	40,1	30.4	HL Board 06 Topline	152786	179597 &	179598 &
178751	40,1	30.4	HL Solid 60 Topline	152789	179671 &	179672 &
178849, 179372	49,9	20.9	HL Board 06 Topline	152786	179607 &	179608 &
178849, 179372	49,9	20.9	HL Solid 60 Topline	152789	179681 &	179682 &
	[mm]	[mm]				

Spare parts

Dimension

Class-No.

Ident-No.

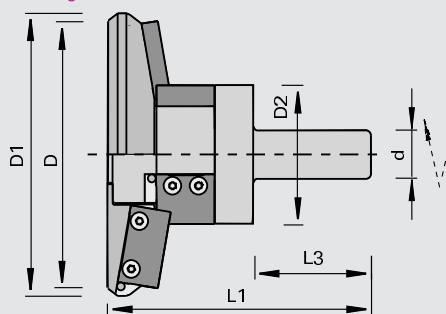
Screws	M4,5x4,6x9 T15	995195	178239
Screwdrivers	T15x80	985730	171188
	[mm]		

128913

EcoPro-Shank-Type Cutterheads HW for panel raising bottom side

Product

Drawing



tungsten carbide [HW]

MEC

Machine / Application

| CNC routers
 | for profiling of solid woods and wood-based panels

Design

| cutting material: HW HL Board 06 for hard woods and wood-based panels
 | cutting material: HW HL Solid 60 for soft woods
 | shank with internal thread M8 for attachment screw

Advantages

| optimum cutting quality even when cutting across the grain of solid woods
 | for panel raising profiles
 | cutterhead body and knives will be profiled according to customer specifications

Notes

| profile knives can be profiled according to customer specifications
 | cutterhead body can be used only for one profile
 | please order stop screw separately

Ø D	Ø D1	Ø D2	Ø d	L3	L1	Z	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
142	144	82	25	60	143	2+2	10000	EP 853 (EP 854+855)	178853 s	179373 s
150	140	82	25	60	143	2+2	7600	EP 848 (EP 854+757)	178848 s	179374 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]		

Blanks for Ident-No.	B	H	LEUCODUR	Class-No.	Ident-No. [L]	Ident-No. [R]
	30,2	30,4	HL Board 06	152586		178528
	30,2	30,4	HL Solid 60	152589		179528
178848, 179374	40,1	30,4	HL Board 06	152586		178534
178848, 179374	40,1	30,4	HL Solid 60	152589		179534
178853, 179373	49,9	20,9	HL Board 06	152586		178539
178853, 179373	49,9	20,9	HL Solid 60	152589		179539
	30,2	30,4	HL Board 06 Topline	152786	179585 &	179586 &
	30,2	30,4	HL Solid 60 Topline	152789	179659 &	179660 &
178848, 179374	40,1	30,4	HL Board 06 Topline	152786	179597 &	179598 &
178848, 179374	40,1	30,4	HL Solid 60 Topline	152789	179671 &	179672 &
178853, 179373	49,9	20,9	HL Board 06 Topline	152786	179607 &	179608 &
178853, 179373	49,9	20,9	HL Solid 60 Topline	152789	179681 &	179682 &
	[mm]	[mm]				

Spare parts	Dimension	Class-No.	Ident-No.
Screws	M4,5x4,6x9 T15	995195	178239
Screwdrivers	T15x80	985730	171188
	[mm]		

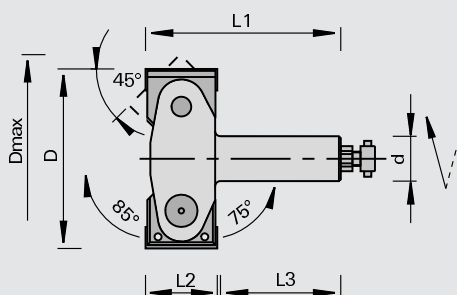
128715

Chamfering Cutterheads HW - pivoting from 0-85 degrees

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

- l CNC routers
- l routers
- l for jointing, chamfering and panel raising in solid woods and wood-based panels
- l for rabbeting with turnover knife Ident-No. 171149

Design

- l cutting edges parallel to cutter axis
- l n max = 12,000 min-1

Advantages

- l universal application

Notes

- l chamfer angle adjustable from 0-85 degrees on high-precision scale
- l for manual feed
- l clamping elements: ps-System, Tribos, draw-in collet chuck, MK2 directly into the spindle

Ø D	Ø Dmax	L2	Ø d	L3	L1	Z	Ident-No.
100	117	40	25	55	110	2	172271
100	117	40	MK 2		125	2	172429 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
	40	12	1.5	150515	164078
	39,5	12	1.5	150515	171149
	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Clamping Bars	38x10,5x6	925300	172272
Safety Screws	M8x25	997870	172113
Safety Screws	M8x19	997870	172921
Set Screws	M6x12 DIN EN ISO 4028	995161	180214
Screwdrivers	SW3x100	985730	166090
Cranked Wrench Keys	SW8 DIN ISO 2936	985730	009677
Special Nuts	M8x11,5	995290	173450
	[mm]		

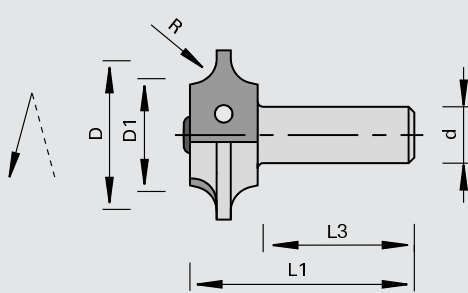
128310

Rounding Cutterheads HW - HOLZ-HER

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

| edgebanders HOLZ-HER
 | for rounding and chamfering of
 solid wood, veneer and plastic
 edge bands

Design

| cutting edges parallel to cutter
 axis
 | cutting material: HW HL Board
 05
 | n max = 30,000 min-1

Advantages

| same cutter head body for
 radius 2-5 mm and chamfer

Notes

| clamping elements: draw-in
 collet chuck

R	Ø D	Ø D1	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
2	30.8	18,85	8	22	43	2	170315	170316
3	30.8	18,85	8	22	43	2	170317	170318
4	30.8	18,85	8	22	43	2		170320 &
5	30.8	18,85	8	22	43	2		170322 &
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Knives	Chamfer	R	B	H	S	Class-No.	Ident-No.
		2	16	17.5	2	151545	163489
		3	16	17.5	2	151545	163490
		4	16	17.5	2	151545	163491
		5	16	17.5	2	151545	163492
	45		16	17.5	2	151545	170329
	[°]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Round Head Screws	M4x5,9 T15	995195	167966
Screwdrivers	T15	985730	163161
	[mm]		

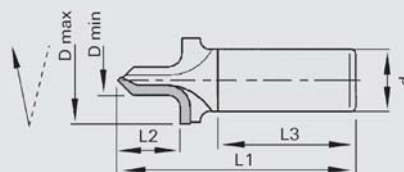
229063 / 229363

LEUCODIA Profiler

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers
 | for profiling of raw and laminated panels

Design

| resharpenable area 2.0mm
 | with shear angle

Advantages

| overlap-free cut thanks to continuous PCD tablets
 | optimum cutting quality in MDF thanks to polished cutting edge face
 | optimum edge quality thanks to shear angle

Notes

| tool can be delivered according to customer specification within the shortest possible time
 | further options are possible at a surcharge: opposing shear angle version ($Z = 1+1$), $Z = 2$ version, different shank length, Topline with ultra fine eroded cutting edge

Ø Dmax	Ø Dmin	L2	Ø d	L3	L1	Z	nmax	Drawing
35	12	25	12	45	85	1	18000	DP1A
35	12	25	16	45	85	1	24000	DP1A
35	12	25	20	45	95	1	24000	DP1A
35	12	25	25	55	95	1	24000	DP1A
26	10	25	12	35	75	1	24000	DP1AK
26	10	25	16	45	85	1	24000	DP1AK
26	10	25	20	45	85	1	24000	DP1AK
26	10	25	25	55	95	1	24000	DP1AK
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]
Ø Dmax	Ø Dmin	L2	Ø d	L3	L1	Z	nmax	Drawing
35	12	12.5	25	55	90	1	24000	DP1M
35	12	12.5	20	45	90	1	24000	DP1M
35	12	12.5	16	45	80	1	24000	DP1M
35	12	12.5	12	45	70	1	24000	DP1M
26	10	12.5	25	55	90	1	24000	DP1MK
26	10	12.5	20	45	80	1	24000	DP1MK
26	10	12.5	16	45	80	1	24000	DP1MK
26	10	12.5	12	35	70	1	24000	DP1MK
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]

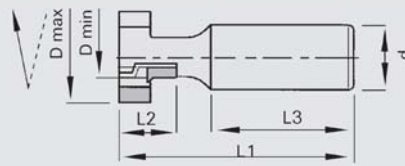
229063 / 229363

LEUCODIA Profiler - T-groove profiles

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for profiling of raw and laminated panels

Design

- | resharpenable area 2.0 mm
- | with shear angle

Advantages

- | overlap-free cut thanks to continuous PCD tablets
- | optimum cutting quality in MDF thanks to polished cutting edge face
- | optimum edge quality thanks to shear angle

Notes

- | tool can be delivered according to customer specification within the shortest possible time
- | further options are possible at a surcharge: opposing shear angle version ($Z = 1+1$), $Z = 2$ version, different shank length, Topline with ultra fine eroded cutting edge

Ø Dmax	Ø Dmin	L2	Ø d	L3	L1	Z	nmax	Drawing
35	10	22	25	55	90	2+1	24000	DP1B
35	10	22	20	45	80	2+1	24000	DP1B
35	10	22	16	45	80	2+1	24000	DP1B
35	10	22	12	35	70	2+1	15700	DP1B
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]

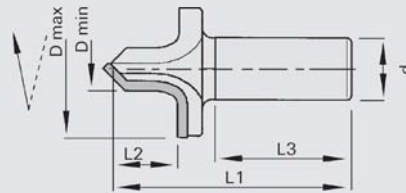
229063 / 229363

LEUCODIA Profiler - large profile depth

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers
 | for profiling of raw and laminated panels

Design

| resharpenable area 2.0 mm
 | with shear angle

Advantages

| overlap-free cut thanks to continuous PCD tablets
 | optimum cutting quality in MDF thanks to polished cutting edge face
 | optimum edge quality thanks to shear angle

Notes

| tool can be delivered according to customer specification within the shortest possible time
 | further options are possible at a surcharge: opposing shear angle version ($Z = 1+1$), $Z = 2$ version, different shank length, Topline with ultra fine eroded cutting edge

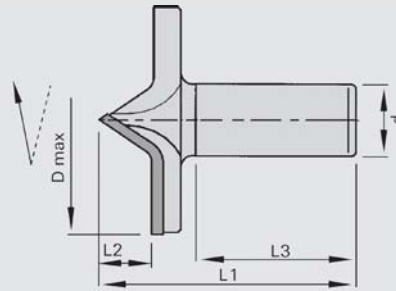
Ø Dmax	Ø Dmin	L2	Ø d	L3	L1	Z	nmax	Drawing
55	16	15	25	55	100	1	24000	DP1CK
55	16	15	20	45	90	1	24000	DP1CK
55	16	15	16	45	90	1	24000	DP1CK
75	18	30	25	55	120	1	24000	DP1D
75	18	30	20	45	110	1	20500	DP1D
75	18	30	16	45	110	1	11200	DP1D
75	18	15	25	55	100	1	17000	DP1DK
75	18	15	20	45	90	1	12900	DP1DK
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]

229063 / 229363

LEUCODIA Profiler - panel raising profiles

Product

Drawing


 LEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers
 | for profiling of raw and laminated panels

Design

| resharpenable area 2.0 mm
 | with shear angle

Advantages

| overlap-free cut thanks to continuous PCD tablets
 | optimum cutting quality in MDF thanks to polished cutting edge face
 | optimum edge quality thanks to shear angle

Notes

| tool can be delivered according to customer specification within the shortest possible time
 | further options are possible at a surcharge: opposing shear angle version ($Z = 1+1$), $Z = 2$ version, different shank length, Topline with ultra fine eroded cutting edge

Ø Dmax	Ø Dmin	L2	Ø d	L3	L1	Z	nmax	Drawing
55	18	25	25	55	110	1	24000	DP1F
55	18	25	20	45	100	1	22000	DP1F
55	18	25	16	45	100	1	12000	DP1F
79		18	25	55	88	1	22000	DP1G
79		18	20	45	78	1	22000	DP1G
79		18	16	45	78	1	15000	DP1G
99		13	25	55	98	1	18000	DP1H
99		13	20	45	88	1	16300	DP1H
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]

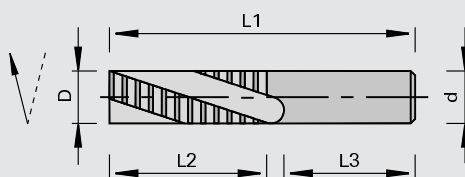
129460

Roughing Cutter with solid carbide body - ECO-disposable

Product



Drawing



Solid Tungsten Carbide

MAN

Machine / Application

| portable routers
 | for cutting of openings in
 countertops and furniture parts
 in hard and exotic woods and
 wood-based panels

Design

| positive spiral

Advantages

| optimum chip evacuation thanks
 to positive spiral
 | high hogging volume thanks to
 rough cutting

Notes

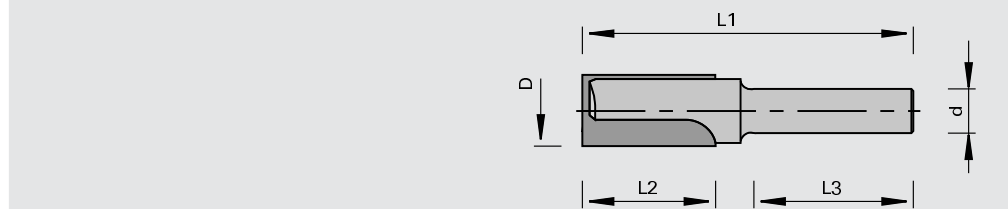
| clamping elements: draw-in
collet chuck

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
12	45	12	35	90	2	178325 o
[mm]	[mm]	[mm]	[mm]	[mm]		

129415

Grooving Cutters HW-tipped - Z=2

Product



tungsten carbide [HW]

MAN

Machine / Application

| portable routers
 | for jointing, rabbeting and
 grooving in solid woods

Design

| cutting edges parallel to cutter
 axis
 | HW-tipped

Advantages

Notes

| face cutting design allows
 plunge-cuts
 | clamping elements: draw-in
 collet chuck

Ø D	L2	Ø d	L1	Z	Ident-No.
3	6	6	39	2	172430 o
4	8	6	40	2	164193 o
4	8	8	40	2	172431 o
5	12	6	42	2	164194 o
5	12	8	42	2	172432
6	14	6	49	2	160364
6	16	8	46	2	167521
8	20	6	50	2	160365
8	20	8	48	2	167522
10	20	6	50	2	160366
10	20	8	48	2	167523
12	20	8	48	2	167524
14	20	6	48	2	160368 o
14	20	8	48	2	167525
15	20	6	48	2	167492 o
16	20	6	48	2	160370 o
[mm]	[mm]	[mm]	[mm]		

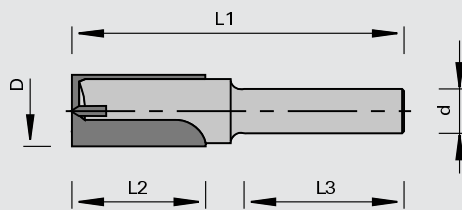
Ø D	L2	Ø d	L1	Z	Ident-No.
16	20	8	48	2	167526
18	20	6	48	2	160371 s
18	20	8	48	2	167527 o
20	20	6	48	2	160372 o
20	20	8	48	2	167528
[mm]	[mm]	[mm]	[mm]		

129415

Grooving Cutters HW-tipped - Z=2 with plunge tip

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

| portable routers
 | for jointing, rabbeting and
 grooving in solid woods

Design

| brazed VHW cutting edge for
 $\varnothing D < 8 \text{ mm}$
 | cutting edges parallel to cutter
 axis
 | HW-tipped

Advantages

Notes

| face cutting design allows
 plunge-cuts
 | clamping elements: draw-in
 collet chuck

Ø D	L2	Ø d	L1	Z	Ident-No.
3	8	8	55	2	167529
4	10	8	55	2	167530
5	12	8	55	2	167531
6	14	8	55	2	167532
8	20	8	55	2	167533
8	30	8	90	2	180823
9	20	8	55	2	167534 o
10	20	8	60	2	167535
10	40	10	97	2	167552
12	20	6	48	2	160367 o
12	20	8	60	2	167536
12	40	10	97	2	167553
14	20	8	60	2	167537 o
14	40	10	97	2	167554 o
16	20	8	70	2	167538 o
16	45	10	97	2	167555 o
18	20	8	70	2	167539
18	45	10	97	2	167556 o
20	45	10	97	2	167557 o
22	16	8	70	2	167540 o
22	25	10	70	2	172433 o
24	16	8	70	2	172434 o
25	16	8	70	2	172435 o
26	16	8	70	2	172436 o
28	16	8	70	2	172437 o
30	16	8	70	2	172438 o
[mm]	[mm]	[mm]	[mm]		

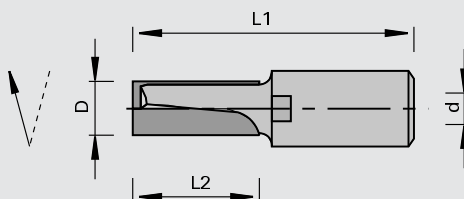
129425

Grooving Cutters HW-tipped - Z=2 with internal thread

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

portable routers
for jointing, rabbeting and
grooving in solid woods

Design

cutting edges parallel to cutter
axis
internal thread allows direct
attachment on the machine
spindle

Advantages

Notes

face cutting design allows
plunge-cuts

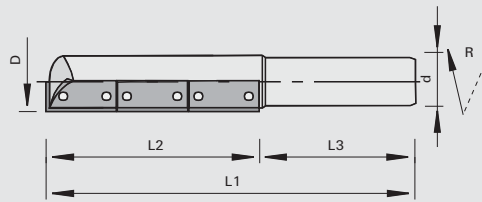
Ø D	L2	Ø d	L1	Z		Ident-No.
8	20	M10	55	2	Scheer	006414 o
10	22	M10	55	2	Scheer	006415 o
16	25	M10	55	2	Scheer	006417 o
16	45	M10	75	2	Scheer	161204
20	25	M10	55	2	Scheer	006418 o
20	45	M10	75	2	Scheer	161205
8	20	M12x1	60	2	ELU, Striffler	167558 o
10	23	M12x1	60	2	ELU, Striffler	167559 o
10	35	M12x1	67	2	ELU, Striffler	161200
12	23	M12x1	60	2	ELU, Striffler	006423 o
14	23	M12x1	60	2	ELU, Striffler	167560 o
14	35	M12x1	67	2	ELU, Striffler	167569 o
15	25	M12x1	60	2	ELU, Striffler	167561 o
16	25	M12x1	60	2	ELU, Striffler	006424
16	45	M12x1	77	2	ELU, Striffler	161201
18	25	M12x1	60	2	ELU, Striffler	167563 o
18	45	M12x1	75	2	ELU, Striffler	167571 o
18	60	M12x1	92	2	ELU, Striffler	178968
20	25	M12x1	60	2	ELU, Striffler	006425
22	25	M12x1	60	2	ELU, Striffler	167564 o
24	25	M12x1	60	2	ELU, Striffler	167565 o
25	25	M12x1	60	2	ELU, Striffler	167566 o
[mm]	[mm]	[mm]	[mm]			

128210

Shank-Type Cutters with HW Turnover Knives for lightweight panels

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

- portable routers
- for jointing, rabbeting and grooving especially in lightweight panels
- for cutting of openings and contours
- dividing cuts can be made in different steps

Design

- suitable for lightweight panels up to a thickness of max. 65 mm
- cutting edge parallel to cutter axis and face cutting
- cutting material: HW HL Board 05

Advantages

- several times a new cutting edge in cover layer possible thanks to interchange of knife inserts among each other
- applicable with all common milling templates

Notes

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [R]
14	69	12	40	110	1	182695 o
[mm]	[mm]	[mm]	[mm]	[mm]		

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [R]
14	69	1/2	40	110	1	182696 o
[mm]	[mm]	[inch]	[mm]	[mm]		

Knives	B	H	S	Class-No.	Ident-No.
	23	7	1.5	150525	182697
	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Head Cap Screws	M3x5,5 T8	995115	168239
Screwdrivers	T8	985720	182698 o
Screwdriver with flag	T8	985730	166499
	[mm]		

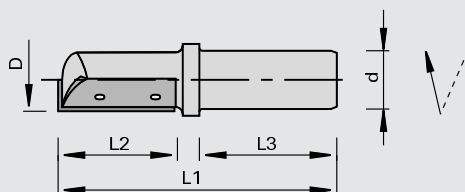
128415

Grooving Cutters with HW Turnover Knives - Z=1

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

l portable routers
l for jointing, rabbeting and
grooving in solid woods and
wood-based panels

Design

l cutting edges parallel to cutter
axis

Advantages

Notes

l face cutting design allows
plunge-cuts to Ø 12.7 mm
l clamping elements: draw-in
collet chuck

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
8	20	8	30	60	1	175673
10	20	8	30	60	1	175674 o
12	20	8	30	60	1	175675 o
14	30	8	30	70	1	175676 o
10	25	10	40	75	1	175678
12	30	10	40	80	1	175679
12.7	30	12,7	40	80	1	175672 o
14	30	10	40	80	1	175680 o
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
for Ø D = 8	20	4.1	1.1	150535	173480
for Ø D = 10+12	20	5.5	1.1	150535	173481
for Ø D = 10	25	5.5	1.1	150535	173793
for Ø D = 12+12,7+14	30	5.5	1.1	150535	173482
	[mm]	[mm]	[mm]		

Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Clamping Wedges	B=20	175673	925500	175722 o
Clamping Wedges	B=20	175674	925500	175723 o
Clamping Wedges	B=25	175678	925500	175724 o
Clamping Wedges	B=20	175675	925500	175725 o
Clamping Wedges	B=30	175672	925500	175727 o
Clamping Wedges	B=30	175679	925500	175726 o
Clamping Wedges	B=30	175676, 175680	925500	175728 o
Head Cap Screws	M2,5x3 T8	175673	995115	168237
Head Cap Screws	M2,5x4 T8	175674, 175678	995115	168238
Head Cap Screws	M3x5,5 T8	175672, 175675, 175676, 175679, 175680	995115	168239
Screwdriver with flag	T8	For all	985730	166499
	[mm]			

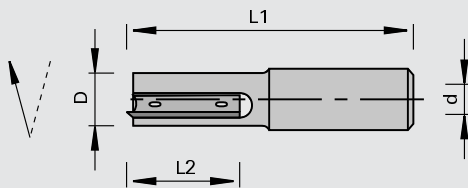
128425

Grooving Cutters with HW Turnover Knives - Z=1 with internal thread

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

| portable routers
 | for jointing, rabbeting and
 grooving in solid woods and
 wood-based panels

Design

| cutting edges parallel to cutter
 axis
 | internal thread allows direct
 attachment on the machine
 spindle

Advantages

Notes

| face cutting design allows
 plunge-cuts to Ø 12 mm

Ø D	L2	Ø d	L1	Z	Ident-No.
8	20	M10	60	1	175681 o
10	25	M10	65	1	175682 o
12	30	M10	72	1	175683 o
14	30	M10	72	1	175684 o
8	20	M12x1	60	1	175685 o
10	25	M12x1	65	1	175686 o
12	30	M12x1	72	1	175687 o
14	30	M12x1	72	1	175688 o
[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
for Ø D = 8	20	4.1	1.1	150535	173480
for Ø D = 10	25	5.5	1.1	150535	173793
for Ø D = 12+14	30	5.5	1.1	150535	173482
	[mm]	[mm]	[mm]		

Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Clamping Wedges	B=20	175681, 175685	925500	175722 o
Clamping Wedges	B=25	175682, 175686	925500	175724 o
Clamping Wedges	B=30	175683, 175687	925500	175726 o
Clamping Wedges	B=30	175684, 175688	925500	175728 o
Head Cap Screws	M2,5x3 T8	175681, 175685	995115	168237
Head Cap Screws	M2,5x4 T8	175682, 175686	995115	168238
Head Cap Screws	M3x5,5 T8	175683, 175684, 175687, 175688	995115	168239
Screwdriver with flag	T8	For all	985730	166499
	[mm]			

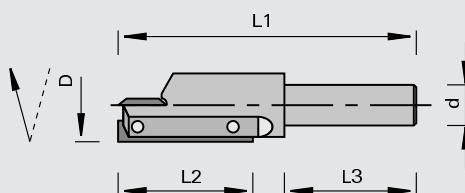
128415

Grooving Cutters with HW Turnover Knives - Z=1 with plunge tip

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

l portable routers
l for jointing, rabbeting and
grooving in solid woods and
wood-based panels

Design

l cutting edges parallel to cutter
axis

Advantages

Notes

l face cutting design allows
plunge-cuts
l clamping elements: draw-in
collet chuck

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
16	30	8	30	71	1+1	175689 o
18	30	8	30	71	1+1	175690 o
20	30	8	30	71	1+1	175691 o
22	30	8	30	71	1+1	175692 o
16	30	10	30	71	1+1	175693 o
18	30	10	30	71	1+1	175694 o
20	30	10	30	71	1+1	175695 o
22	30	10	30	71	1+1	175696 o
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
Turnover Knives	12	12	1.5	150515	003080
Mini Turnover Knives	30	5.5	1.1	150535	173482
	[mm]	[mm]	[mm]		

Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Clamping Wedges	B=30	175689, 175693	925500	169280 o
Clamping Wedges	B=30	175690, 175694	925500	169281 o
Clamping Wedges	B=30	175691, 175695	925500	169282 o
Clamping Wedges	B=30	175692, 175696	925500	169283 o
Head Cap Screws	M3,5x5,5 T15	175689, 175690, 175693, 175694	995115	168236
Head Cap Screws	M3,5x6,5 T15	175691, 175692, 175695, 175696	995115	163223
Round Head Screws	M4x5,9 T15		995195	167966
Screwdrivers	T15		985730	163161
	[mm]			

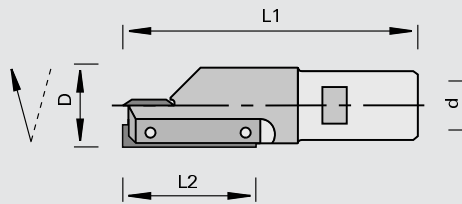
128425

Grooving Cutters with HW Turnover Knives - Z=1 with plunge tip and internal thread

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

| portable routers
 | for jointing, rabbeting and
 grooving in solid woods and
 wood-based panels

Design

| cutting edges parallel to cutter
 axis
 | internal thread allows direct
 attachment on the machine
 spindle

Advantages

Notes

| face cutting design allows
 plunge-cuts

Ø D	L2	Ø d	L1	Z	Ident-No.
16	30	M10	65	1+1	175697 o
18	30	M10	65	1+1	175698 o
20	30	M10	65	1+1	175699 o
22	30	M10	65	1+1	175700 o
16	30	M12x1	65	1+1	175701
18	30	M12x1	65	1+1	175702 o
20	30	M12x1	65	1+1	175703
22	30	M12x1	65	1+1	175704 o
[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
Turnover Knives	12	12	1.5	150515	003080
Mini Turnover Knives	30	5.5	1.1	150535	173482
	[mm]	[mm]	[mm]		

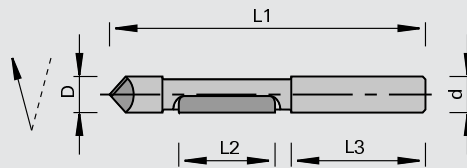
Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Clamping Wedges	B=30	175697, 175701	925500	169280 o
Clamping Wedges	B=30	175698, 175702	925500	169281 o
Clamping Wedges	B=30	175699, 175703	925500	169282 o
Clamping Wedges	B=30	175700, 175704	925500	169283 o
Head Cap Screws	M3,5x5,5 T15	175697, 175698, 175701, 175702	995115	168236
Head Cap Screws	M3,5x6,5 T15	175699, 175700, 175703, 175704	995115	163223
Round Head Screws	M4x5,9 T15		995195	167966
Screwdrivers	T15		985730	163161
	[mm]			

129417

Plunge Cutters HW-tipped

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

l portable routers
l for cutting of openings in solid woods

Design

l cutting edges parallel to cutter axis

Advantages

Notes

l face cutting design allows plunge-cuts
l clamping elements: draw-in collet chuck

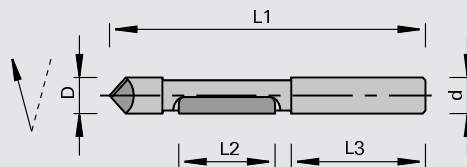
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
6	19	6	25	65	1+1	006453
6.35	20	6,35	25	63	1+1	167661 o
[mm]	[mm]	[mm]	[mm]	[mm]		

329417

Plunge Cutters HS-tipped

Product

Drawing



High Speed Steel [HS]

MAN

Machine / Application

l portable routers
l for cutting of openings in solid woods

Design

l cutting edges parallel to cutter axis

Advantages

Notes

l face cutting design allows plunge-cuts
l clamping elements: draw-in collet chuck

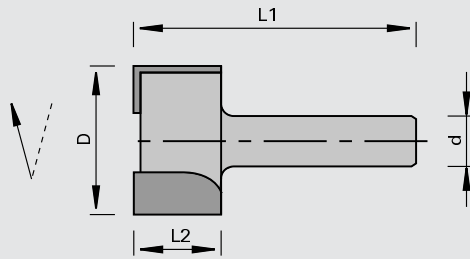
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
6.4	15	6	25	56	1+1	170757
6.4	15	6	25	70	1+1	170758
[mm]	[mm]	[mm]	[mm]	[mm]		

129215

Edge Trimming Cutters HW-tipped

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

portable routers
for jointing and rabbeting in
solid woods and wood-based
panels

Design

cutting edges parallel to cutter
axis
face cutting and peripheral
cutting

Advantages

Notes

clamping elements: draw-in
collet chuck

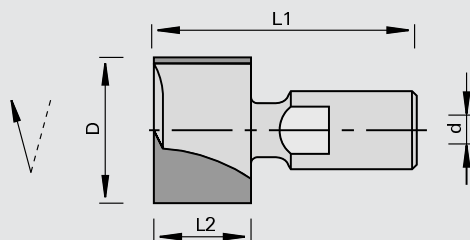
Ø D	L2	Ø d	L1	Z	Ident-No.
18	12	6	37	2	164307 o
20	16	6	41	2	006146 o
24	16	6	41	2	167573 o
31	16	6	41	2	167574 o
18	12	8	37	2	164308 o
20	16	8	41	2	160357 o
24	16	8	41	2	167575 o
31	16	8	41	2	167576 o
24	16	10	41	2	167577 o
31	16	10	41	2	167578 o
24	16	12	41	2	167579 o
31	16	12	41	2	167580 o
[mm]	[mm]	[mm]	[mm]		

129225

Edge Trimming Cutters HW-tipped with internal thread

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

portable routers
for jointing and rabbeting in
solid woods and wood-based
panels

Design

cutting edges parallel to cutter
axis
face cutting and peripheral
cutting
shank with internal thread

Advantages

Notes

Ø D	L2	Ø d	L1	Z	Ident-No.
24	16	M10	41	2	167581 o
31	16	M10	41	2	167582 o
24	16	M12x1	41	2	167583 o
31	16	M12x1	41	2	167584 o
[mm]	[mm]	[mm]	[mm]		

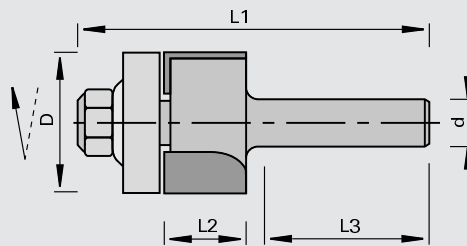
129216

Edge Trimming Cutters HW-tipped with thrust ring

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

| portable routers
 | for flush-cutting of solid wood, veneer and plastic edge bands and copying in solid woods and wood-based panels

Design

| cutting edges parallel to cutter axis
 | flush-cutting with ball-bearing mounted rub collar

Advantages

Notes

| template copying
 | clamping elements: draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
12.7	25	8	25	58	2	180822
22	16	6	25	58	2	006152
22	16	6,35	25	58	2	167585 o
22	16	8	25	58	2	164215
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts

Dimension

Class-No.

Ident-No.

Ball Bearings	12,7x5x4,76	997500	164920
Ball Bearings	22x7,5x6,35	997500	164228
Ball Bearings	22x7,5x8	997500	180838
Hexagon Nuts	M4 DIN EN ISO 4032	995210	009631
Hexagon Nuts	M6 DIN EN ISO 4032	995210	009633
	[mm]		

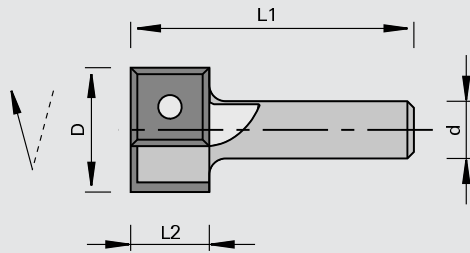
128215

Edge Trimming Cutters with HW TOK

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

| portable routers
 | for jointing and rabbeting in
 solid woods and wood-based
 panels

Design

| face cutting
 | cutting edges parallel to cutter
 axis
 | n max = 27,000 min-1

Advantages

Notes

| clamping elements: draw-in
collet chuck

Ø D	L2	Ø d	L1	Z		Ident-No. [L]	Ident-No. [R]
19	12	6	42	2			164897 o
19	12	6,35	42	2			164901 o
19	12	8	46	2	Brandt	833907 s	164905 o
[mm]	[mm]	[mm]	[mm]				

Turnover Knives	B	H	S	Class-No.	Ident-No.
	12	12	1.5	150515	003080
	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Round Head Screws	M4x5,9 T15	995195	167966
Screwdrivers	T15	985730	163161
	[mm]		

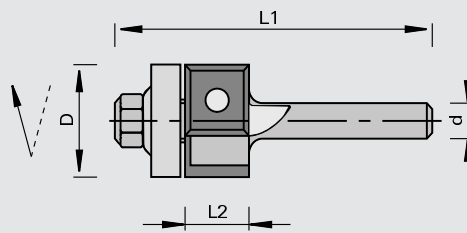
128216

Edge Trimming Cutters with HW Turnover Knives with thrust ring

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

| portable routers
 | for flush-cutting of solid wood, veneer and plastic edge bands and copying in solid woods and wood-based panels

Design

| cutting edges parallel to cutter axis
 | flush-cutting with ball-bearing mounted rub collar

Advantages

Notes

| template copying
 | clamping elements: draw-in collet chuck

Ø D	L2	Ø d	L1	Z	Ident-No.
19	12	6,35	56	2	164912 o
19	12	8	56	2	164916
19	30	8	74	2	183398
19	50	12	112	2	183399
[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
	12	12	1.5	150515	003080
	30	12	1.5	150515	003083
	50	12	1.5	150515	003085
	[mm]	[mm]	[mm]		

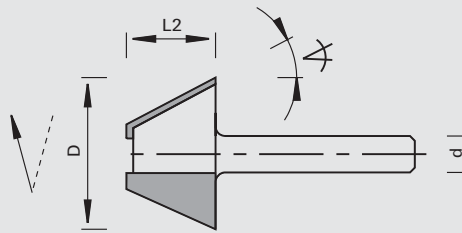
Spare parts	Dimension	Class-No.	Ident-No.
Ball Bearings	19x6x6	997500	164922
Round Head Screws	M4x5,9 T15	995195	167966
Screwdrivers	T15	985730	163161
	[mm]		

129315

Edge Chamfering Cutters HW-tipped

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

| portable routers
 | for chamfering in solid woods
 and wood-based panels

Design

| cutting edges parallel to cutter
 axis

Advantages

Notes

| clamping elements: draw-in
 collet chuck

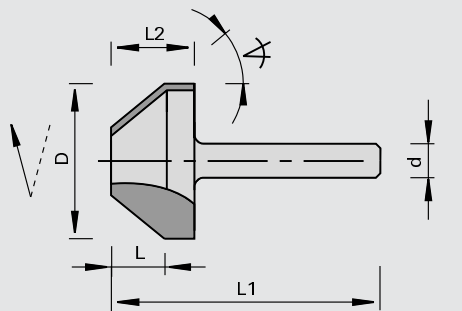
Chamfer	Ø D	L2	Ø d	Z	Ident-No.
15	24	12	6	2	006160 o
15	24	12	6,35	2	167586 o
15	24	12	8	2	164220 o
22	24	12	6,35	2	167587 o
30	24	12	6	2	006161 o
30	24	12	6,35	2	167588 o
30	24	12	8	2	164221 o
[°]	[mm]	[mm]	[mm]		

129315

Edge Chamfering Cutters HW-tipped - chamfer angle 45°, shank can be exchanged

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

| portable routers
 | for chamfering in solid woods
 and wood-based panels

Design

| cutting edges parallel to cutter
 axis
 | shank can be exchanged

Advantages

Notes

| clamping elements: draw-in
 collet chuck

Chamfer	Ø D	L2	L	Ø d	Z	Ident-No.
45	31	15	10	6	2	167589 o
45	31	15	10	6,35	2	167590 o
45	31	15	10	8	2	167591 o
45	31	15	10	10	2	167592 o
45	31	15	10	12	2	167593 o
[°]	[mm]	[mm]	[mm]	[mm]		

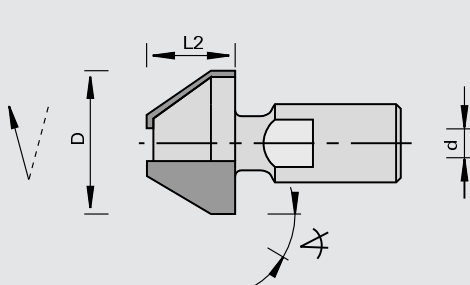
129325

Edge Chamfering Cutters HW-tipped - chamfer angle 45°, with internal thread

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

l portable routers
l for chamfering in solid woods and wood-based panels

Design

l cutting edges parallel to cutter axis
l shank with internal thread

Advantages

Notes

Chamfer $\angle$	$\varnothing D$	L2	$\varnothing d$	Z	Ident-No.
45	31	15	M10	2	167594 o
45	31	15	M12	2	167595 o
[°]	[mm]	[mm]	[mm]		

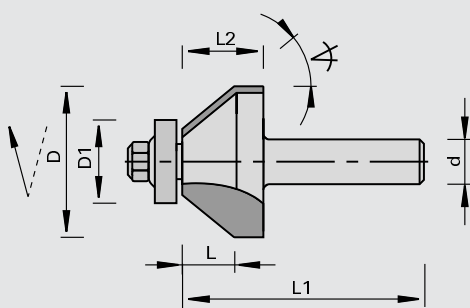
129316

Edge Chamfering Cutters HW-tipped with thrust ring

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

l portable routers
l for chamfering of solid wood, veneer and plastic edge bands and copying in solid woods and wood-based panels

Design

l cutting edges parallel to cutter axis
l flush-cutting with ball-bearing mounted rub collar

Advantages

Notes

l template copying with chamfer
l clamping elements: draw-in collet chuck

Chamfer $\angle$	$\varnothing D$	$\varnothing D1$	L2	L	$\varnothing d$	L1	Z	Ident-No.
45	25	15,9	12	6	6	37	2	160361
45	25	15,9	12	6	8	37	2	167597
30	26	15,9	12	12	6	37	2	160360 o
30	26	15,9	12	12	8	37	2	167596 o
[°]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts

Dimension

Class-No.

Ident-No.

Ball Bearings	15,9x5x6,35	997500	164921
Hexagon Nuts	M6 DIN EN ISO 4032	995210	009633
	[mm]		

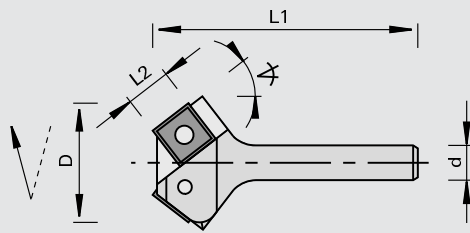
128315

Edge Chamfering Cutters with HW TOK

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

| portable routers
 | for chamfering in solid woods
 and wood-based panels

Design

| cutting edges parallel to cutter
 axis

Advantages

Notes

| clamping elements: draw-in
 collet chuck

Chamfer∠	Ø D	L2	Ø d	L1	Z		Ident-No. [L]	Ident-No. [R]
15	21.96	10.5	8	45	2	Brandt	777160 s	773158 s
22	24	12	6	45	2			164898 o
22	24	12	6,35	45	2			164902 o
30	25	12	6	45	2			164899 o
30	25	12	6,35	45	2			164903 o
30	25	12	8	54	2			164906 o
45	29	12	6	45	2			164900 o
45	29	12	6,35	45	2			164904 o
45	29	12	8	54	2			164907 o
[°]	[mm]	[mm]	[mm]	[mm]				

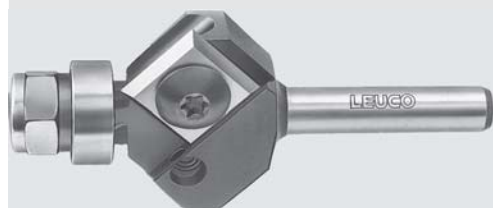
Turnover Knives	B	H	S	Class-No.	Ident-No.
	10,5	10.5	1.5	150518	162316
	12	12	1.5	150515	003080
	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Round Head Screws	M4x5,9 T15	995195	167966
Screwdrivers	T15	985730	163161
	[mm]		

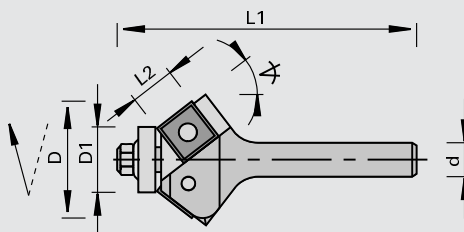
128316

Edge Chamfering Cutters with HW Turnover Knives with thrust ring

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

| portable routers
 | for chamfering of solid wood, veneer and plastic edge bands and copying in solid woods and wood-based panels

Design

| cutting edges parallel to cutter axis
 | flush-cutting with ball-bearing mounted rub collar

Advantages

Notes

| template copying
 | clamping elements: draw-in collet chuck

Chamfer	Ø D	Ø D1	L2	Ø d	L1	Z	Ident-No.
10	22	19	12	6	48	2	164909 o
10	22	19	12	6,35	48	2	164913 o
10	22	19	12	8	56	2	164917 o
45	29	12,7	12	6	56	2	164911
45	29	12,7	12	8	64	2	164918
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
	12	12	1.5	150515	003080
	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Ball Bearings	12,7x5x4,76	997500	164920
Ball Bearings	19x6x6	997500	164922
Round Head Screws	M4x5,9 T15	995195	167966
Screwdrivers	T15	985730	163161
	[mm]		

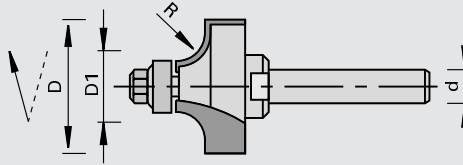
129616

Rounding Cutters HW-tipped with thrust ring

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

| portable routers
 | for rounding of solid wood, veneer and plastic edge bands as well as solid woods and wood-based panels

Design

| cutting edges parallel to cutter axis
 | rounding with ball-bearing mounted rub collar

Advantages

Notes

| template copying
 | clamping elements: draw-in collet chuck

R	Ø D	Ø D1	Ø d	Z		Ident-No.
2	16	12	8	2		180824
2	18	12	6	2	EBM	816995
3	18	12	6	2		167598
3	18	12	6,35	2		167599 o
3	18	12	8	2		167600
3	20	12	6	2	EBM	816994 o
4	20	12	6	2		167601 o
4	20	12	6,35	2		167602 o
4	20	12	8	2		167603
5	22	12	6	2		167604
5	22	12	6,35	2		167605 o
5	22	12	8	2		167606
6,3	24	12	6,35	2		167608 o
6,3	24.6	12	6	2		167607 o
6,3	24.6	12	8	2		167609
8	30	14	6	2		167610 o
8	30	14	6,35	2		167611 o
8	30	14	8	2		167612
9,5	33	14	6	2		167613 o
9,5	33	14	6,35	2		167614 o
9,5	33	14	8	2		167615
12,7	39.4	14	6	2		167616 o
12,7	39.4	14	6,35	2		167617 o
12,7	39.4	14	8	2		167618
[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

Ident-No.

Ball Bearings	Ø12	997500	167923
Ball Bearings	Ø14	997500	169314
	[mm]		

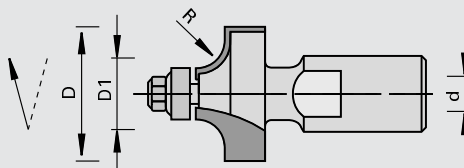
129626

Rounding Cutters HW-tipped with thrust ring and internal thread

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

| portable routers
 | for rounding of solid wood, veneer and plastic edge bands as well as solid woods and wood-based panels

Design

| cutting edges parallel to cutter axis
 | shank with internal thread
 | rounding with ball-bearing mounted rub collar

Advantages

Notes

| template copying

R	Ø D	Ø D1	Ø d	Z	Ident-No.
3	18	12	M10	2	167619 o
3	18	12	M12x1	2	167620 o
4	20	12	M10	2	167621 o
4	20	12	M12x1	2	167622 o
5	22	12	M10	2	167623 o
5	22	12	M12x1	2	167624 o
6,3	24.6	12	M10	2	167625 o
6,3	24.6	12	M12x1	2	167626 o
8	30	14	M10	2	167627 o
8	30	14	M12x1	2	167628 o
9,5	33	14	M10	2	167629 o
9,5	33	14	M12x1	2	167630 o
12,7	39.4	14	M10	2	167631 o
12,7	39.4	14	M12x1	2	167632 o
[mm]	[mm]	[mm]	[mm]		

Spare parts

Dimension

Class-No.

Ident-No.

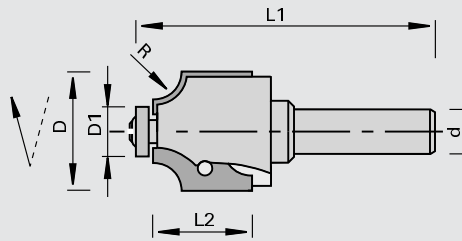
Ball Bearings	Ø12	997500	167923
Ball Bearings	Ø14	997500	169314
	[mm]		

128616

Rounding and Quarter Round Cutterheads HW

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

| portable routers
 | for rounding and quarter round
 cutting in solid woods and
 wood-based panels

Design

| with ball-bearing spacer ring
 | profiled turnover knives
 | face cutting and peripheral
 cutting

Advantages

Notes

| included in delivery: 2 ball
 bearing sets (see D1)
 | included in delivery Ident-No.
 180947: 1 ball bearing set
 | exchangeable ball bearing
 sets: 1. with big spacer set /
 2. with small spacer set/ 3.
 without spacer set

R	Ø D	Ø D1	L2	Ø d	L1	Z	Ident-No.
2	26	22	19.5	8	70	2	180947 o
3	26	20/18	19.5	8	70	2	180948 o
4	26	18/14	19.5	8	70	2	180949 o
5	26	16/12	19.5	8	70	2	180950 o
6	32	20/16	26	8	76	2	180951 o
8	32	16/12	26	8	76	2	180952 o
10	36	16/12	30	8	80	2	180953 o
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Knives	R	B	H	S	Class-No.	Ident-No.
	2	19,5	9	1.5	151555	180991 o
	3	19,5	9	1.5	151555	180992 o
	4	19,5	9	1.5	151555	180993 o
	5	19,5	9	1.5	151555	180994 o
	6	26	12.5	1.5	151555	180995 o
	8	26	12.5	1.5	151555	180996 o
	10	30	14.5	1.5	151555	180997 o
	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Ball Bearings	Ø12	997500	167923
Ball Bearings	Ø14	997500	169314
Ball Bearings	Ø16	997500	180985 o
Ball Bearings	Ø18	997500	180986 o
Ball Bearings	Ø20	997500	180987 o
Ball Bearings	Ø22	997500	180988 o
Head Cap Screws	M4x6 T15	995195	180989 o
Round Head Screws	M4x5,9 T15	995195	167966
Cover Screws	M3,5	995195	180990 o
Screwdrivers	T15	985730	163161
	[mm]		

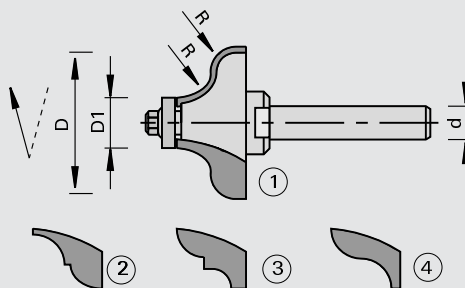
129616

Profile Cutters HW-tipped with thrust ring

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

| portable routers
 | for profiling of edges and copying in solid woods

Design

| 2 cutting edges parallel to cutter axis
 | profiling with ball-bearing mounted rub collar

Advantages

Notes

| template copying with profile
 | clamping elements: collet chuck

R	Ø D	Ø D1	Ø d	Z	Profile	Ident-No.
7,2 / 7,2	37.4	12	6	2	1	167646 o
7,2 / 7,2	37.4	12	6,35	2	1	167647 o
7,2 / 7,2	37.4	12	8	2	1	167648 o
6,3 / 6,3	37.2	12	6	2	2	167651 o
6,3 / 6,3	37.2	12	6,35	2	2	167652 o
6,3 / 6,3	37.2	12	8	2	2	167653 o
6,3 / 6,3	41.2	12	8	2	3	167658 o
4 / 4	31	12	6	2	4	167636 o
4 / 4	31	12	6,35	2	4	167637 o
4 / 4	31	12	8	2	4	167638 o
6,3/6,3	37	12	6	2	4	167639 o
6,3/6,3	37	12	6,35	2	4	167640 o
6,3/6,3	37	12	8	2	4	167641 o
[mm]	[mm]	[mm]	[mm]			

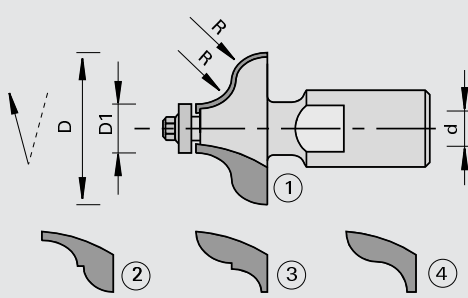
129626

Profile Cutters HW-tipped with thrust ring and internal thread

Product



Drawing


 LEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

- portable routers
- for profiling of edges and copying in solid woods

Design

- 2 cutting edges parallel to cutter axis
- shank with internal thread
- profiling with ball-bearing mounted rub collar

Advantages

Notes

- template copying with profile

R	Ø D	Ø D1	Ø d	Z	Profile	Ident-No.
7,2 / 7,2	37.4	12	M10	2	1	167649 o
7,2 / 7,2	37.4	12	M12x1	2	1	167650 o
6,3 / 6,3	37.2	12	M10	2	2	167654 o
6,3 / 6,3	37.2	12	M12x1	2	2	167655 o
6,3 / 6,3	41.9	12	M10	2	3	167659 o
6,3 / 6,3	41.9	12	M12x1	2	3	167660 o
4 / 4	31	12	M10	2	4	167642 o
4 / 4	31	12	M12x1	2	4	167643 o
6,3 / 6,3	37	12	M10	2	4	167644 o
6,3 / 6,3	37	12	M12x1	2	4	167645 o
[mm]	[mm]	[mm]	[mm]			

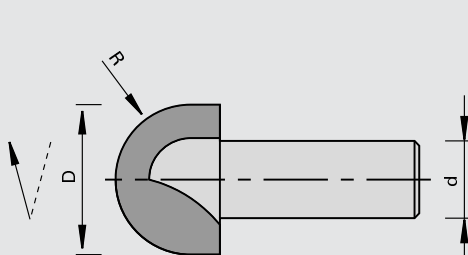
129615

Cove Cutters HW-tipped

Product



Drawing


 LEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

- portable routers
- for cutting of coves and semi-coves in solid woods and wood-based panels

Design

- 2 cutting edges parallel to cutter axis

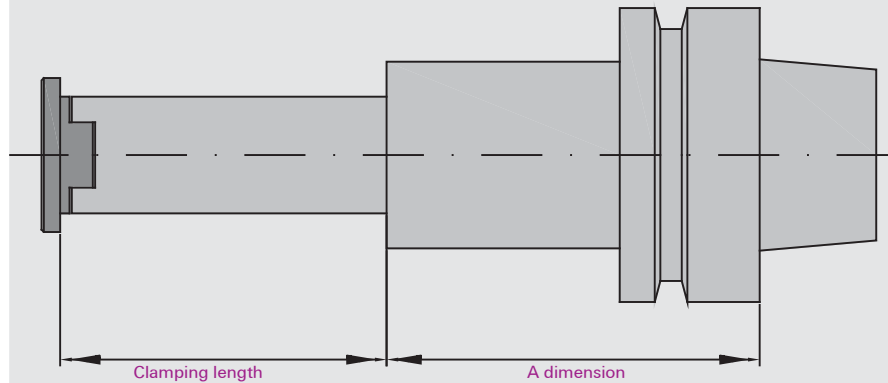
Advantages

Notes

- clamping elements: collet chuck

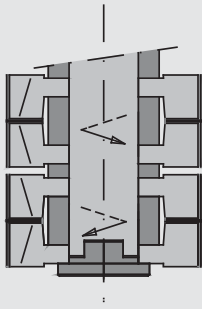
R	Ø D	Ø d	L1	Z	Ident-No.
4,75	9.5	8	60	2	167633 o
5,5	11	8	60	2	167634 o
6,35	12.7	8	60	2	167635
[mm]	[mm]	[mm]	[mm]		

Modula Order Data

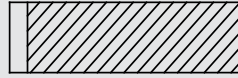


- | The Modula-system is a modern tool-system for CNC-machines
- | Thanks to its modular structure many profile variations can be made up
- | On the following pages please find the most important standard combinations, the individual cutterheads and the holder shanks
- | Note: all combinations do not include drive arbors. Please order separately and indicate dimension „A“ and clamping length required
- | Sets include spacers; tool-cards not included
- | the Modula cutterheads are supplied without adjustment gauges and wrenches; please order separately (mounting set Ident-No. 9210474)
- | For custom combinations please contact your LEUCO representative
- | Tool identification card Ident-No. 171407 EUR 28.30

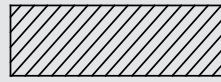
Modula Jointing Sets Application



Section cut lefthand

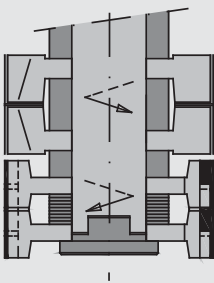


Modula Jointing Cutter with TOK for chamfering on lefthand

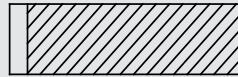


In combination with Modula jointing cutter for finish cutting righthand

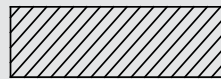
Finish cut righthand



Section cut lefthand

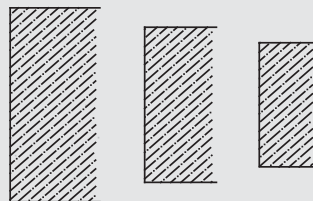
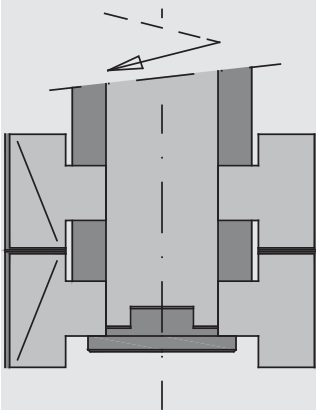


Modula Jointing Cutter with TOK for chamfering on lefthand and for veneer overhangs



In combination with LEUCODIA jointing cutter for finish cutting righthand

Finish cut righthand



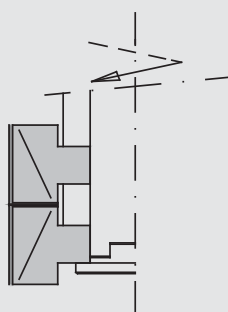
128660

Modula Jointing Sets HW

Product



Drawing

LEUCO
CNC

tungsten carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for jointing in laminated panels

Design

- | opposing shear cut
- | tool set 2 parts
- | basis number of wings Z=2
- | n max = 14,500 min-1

Advantages

Notes

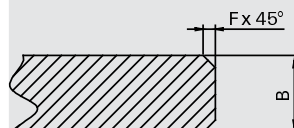
- | for more options see application examples
- | wrenches are not included in delivery
- | mounting-set Ident-No. 198948
- | please order shank-tool holder separately

Ø D	B	Ø d	Z		Ident-No.
70	28	25	2	O-1, O-2	199377
70	38	25	2	C-1, C-2	199380
70	58	25	2	H-1, H-2	199382
70	78	25	2	J-1, J-2	199383
[mm]	[mm]	[mm]			

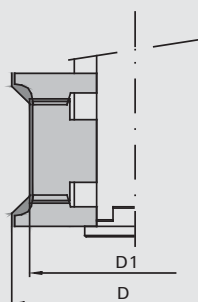
128660

Modula Chamfering Sets HW

Product



Drawing

LEUCO
CNC

tungsten carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for jointing and rabbeting in solid woods and wood-based panels

Design

- | jointing cutterheads up to B = 40 mm with shear angle
- | unchanging zero-point
- | n max = 14,500 min-1

Advantages

- | simple adjustment by means of rings
- | high flexibility thanks to modular design

Notes

- | expandable by concave or radius cutterheads
- | for more options see application examples
- | wrenches are not included in delivery
- | mounting-set Ident-No. 198948
- | please order shank-tool holder separately

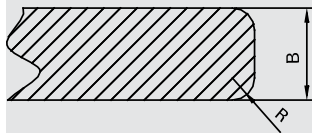
Chamfer↙	Ø D	Ø D1	B	Ø d	Z		Ident-No.
3x45	78	70	8 - 23	25	2	B, C-1, B	199335
3x45	78	70	14 - 33	25	2	B, H-1, B	199338
3x45	78	70	24 - 43	25	2	B, J-1, B	199341
3x45	78	70	34 - 63	25	2	B, S-1, B	199753
3x45	78	70	54 - 75	25	2	B, M-1, B	199754
[°]	[mm]	[mm]	[mm]	[mm]			

Chamfer	Ø D	Ø D1	B	Ø d	Z		Ident-No.
5x45	82	70	18 - 28	25	2	F-1, C-1, F-2	199344
5x45	82	70	23 - 38	25	2	F-1, H-1, F-2	199348
5x45	82	70	33 - 48	25	2	F-1, J-1, F-2	199352
5x45	82	70	38 - 68	25	2	F-1, S, F-2	199765
5x45	82	70	58 - 74	25	2	F-1, M, F-2	199766
10x45	90	70	22 - 38	25	2	U-1, C-1, U-2	199356
10x45	90	70	22 - 48	25	2	U-1, H-1, U-2	199359
10x45	90	70	29 - 58	25	2	U-1, J-1, U-2	199362
10x45	90	70	38 - 72	25	2	U-1, S, U-2	199767
10x45	90	70	58 - 74	25	2	U-1, M, U-2	199768
[°]	[mm]	[mm]	[mm]	[mm]			

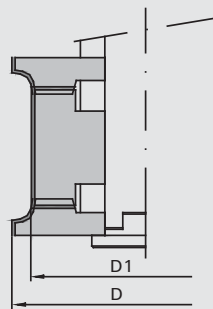
128660

Modula Rounding Sets HW

Product



Drawing



LEUCO
CNC

tungsten carbide [HW]

MEC

Machine / Application

| CNC routers
 | for jointing and rounding in solid woods and wood-based panels

Design

| jointing cutterheads up to B = 40 mm with shear angle
 | radius cutterheads from R 4 with shear angle
 | unchanging zero-point
 | n max = 14,500 min-1

Advantages

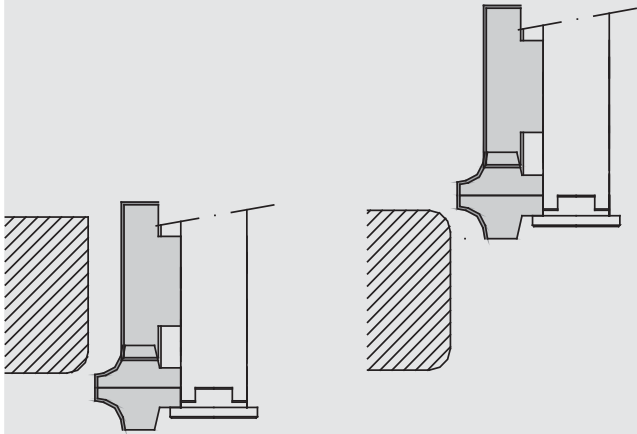
| simple adjustment by means of rings
 | high flexibility thanks to modular design

Notes

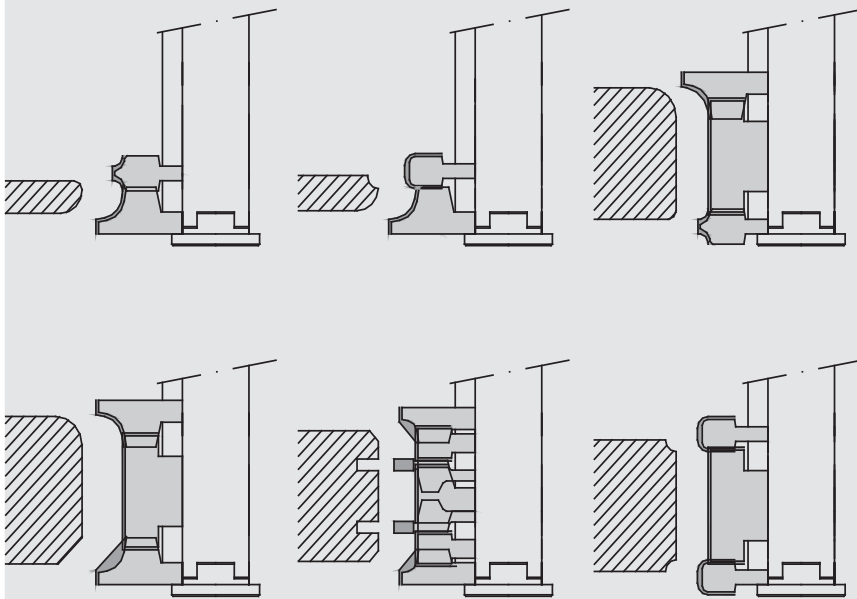
| expandable by concave or chamfering cutterheads
 | for more options see application examples
 | wrenches are not included in delivery
 | mounting-set Ident-No. 198948
 | please order shank-tool holder separately

R	Ø D	Ø D1	B	Ø d	Z		Ident-No.
2, 3	78	70	8 - 21	25	2	B, C-1, B	199336
2, 3	78	70	14 - 31	25	2	B, H-1, B	199339
2, 3	78	70	24 - 41	25	2	B, J-1, B	199342
2, 3	78	70	34 - 62	25	2	B, S, B	199749
2, 3	78	70	54 - 75	25	2	B, M, B	199750
4, 5, 6	82	70	16 - 26	25	2	F-1, C-1, F-2	199345
4, 5, 6	82	70	20 - 36	25	2	F-1, H-1, F-2	199349
4, 5, 6	82	70	30 - 46	25	2	F-1, J-1, F-2	199353
4, 5, 6	82	70	40 - 66	25	2	F-1, S, F-2	199755
4, 5, 6	82	70	60 - 74	25	2	F-1, M, F-2	199756
8, 10	90	70	22 - 34	25	2	U-1, C-1, U-2	199357
8, 10	90	70	22 - 44	25	2	U-1, H-1, U-2	199360
8, 10	90	70	29 - 54	25	2	U-1, J-1, U-2	199363
8, 10	90	70	38 - 72	25	2	U-1, S, U-2	199761
8, 10	90	70	58 - 74	25	2	U-1, M, U-2	199762
[mm]	[mm]	[mm]	[mm]	[mm]			

Modula Application Examples



Other combinations



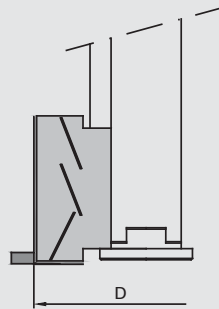
- | If material thicknesses vary considerably, both cutterheads are mounted on the bottom
- | The material-thicknesses are entered into the program and the milling is done in two passes

128660

Modula Jointing / Rabbeting Cutterheads HW

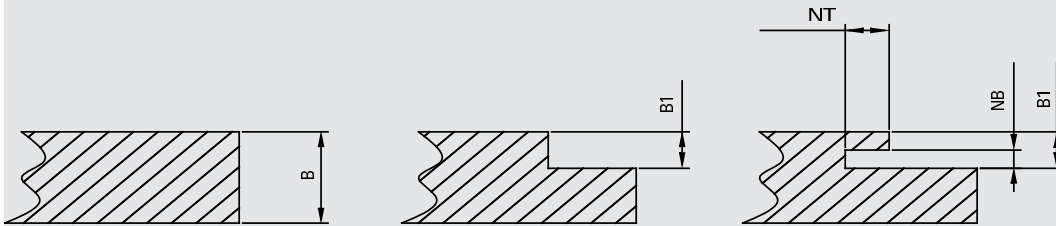
Product

Drawing

LEUCO
CNC

tungsten carbide [HW]

MEC



Machine / Application

| CNC routers
 | for jointing and rabbeting in
 solid woods and wood-based
 panels

Design

| aluminum body
 | with alternating shear angle
 | spiral cutting edges
 | basis number of wings Z=2
 | n max = 15,000 min-1

Advantages

| high performance with low
 cutting pressure

Notes

| optionally grooving knives can
 be used
 | wrenches are not included in
 delivery
 | mounting-set Ident-
 No. 198948
 | please order shank-tool holder
 separately

Ø D	B	B1	Ø d	Z	Ident-No.
80	71	20-70	25	2+2	9203782
80	91	20-90	25	2+2	9206050
[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
Spurs	14	14	2	150559	003079
turnover knives up to the year 2006	16	12	1.5	150515	876623
Turnover Knives	18	12	1.5	150515	9206316
Turnover Knives	20	12	1.5	150515	9215959
	[mm]	[mm]	[mm]		

Options additional grooving knives	B	Tmax	Class-No.	Ident-No.
	4	8	150512	879869
	5	8	150512	888748
	[mm]	[mm]		

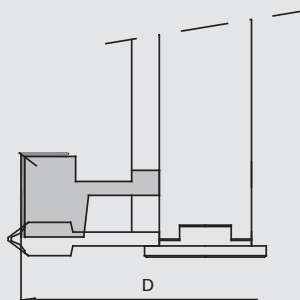
Spare parts	Dimension	Class-No.	Ident-No.
Countersunk Flat Headed Screws	M5x11 T20	995125	879871
Clamping Bars	6x	925300	872689
Clamping Bars	2x	925300	9203785
Set Screws	M6x16 SW3	995161	001617
Countersunk Flat Headed Screws for spur	M5x7 T15	995125	900512
	[mm]		

128660

Modula Rabbeting Cutterheads HW - Z=2

Product

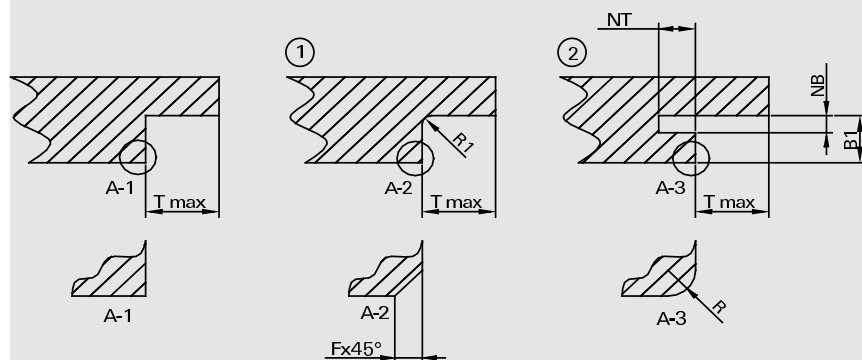
Drawing

LEUCO
CNC

tungsten carbide [HW]

MEC

Application example



Machine / Application

| CNC routers
 | for jointing and rabbeting in
 solid woods and wood-based
 panels

Design

| with shear angle
 | basis number of wings Z=2
 | Ø 100: n max = 14,500 min-1
 / Ø 130: n max = 11,500
 min-1

Advantages

| high flexibility thanks to modular
 design

Notes

| optionally grooving knives can
 be used
 | expandable by radius or
 chamfering cutterheads
 | wrenches are not included in
 delivery
 | mounting-set Ident-
 No. 198948
 | please order shank-tool holder
 separately

Ø D	B	Ø d	Tmax	Z	Ident-No.
100	30	25	25	2+2V T-3	888524
100	40	25	25	2+2V T-10	889428
130	30	25	25	2+2V T-5	888525
[mm]	[mm]	[mm]	[mm]		

Turnover Knives	R	B	H	S	Class-No.	Ident-No.
Radius Spurs	1	13	15	2	150552	888476
	[mm]	[mm]	[mm]	[mm]		

Grooving Knives	B	Tmax	Class-No.	Ident-No.
	4	8	150512	879869
	5	8	150512	888748
	[mm]	[mm]		

Spare parts

Dimension

Class-No.

Ident-No.

Countersunk Flat Headed Screws	for grooving knife	M5x11 T20	995125	879871
		[mm]		

Options	R	Chamfer	Ø D	Cutterhead	Class-No.	Ident-No.
A-2		45	108	A	120610	879845
A-3	2		108	A	120660	881168
A-3	3		108	A	120660	881169
	[mm]	[°]	[mm]			

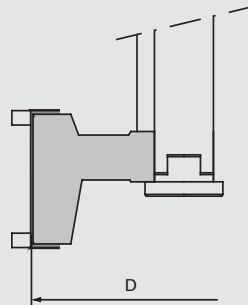
Options	R	Chamfer ∇	Ø D	Cutterhead	Class-No.	Ident-No.
A-2		45	138	Y	120610	880580
A-3	2		138	Y	120660	880581
A-3	3		138	Y	120660	880582
	[mm]	[°]	[mm]			

120210

Modula Single Rabbeting Cutterheads HW - Z=3

Product

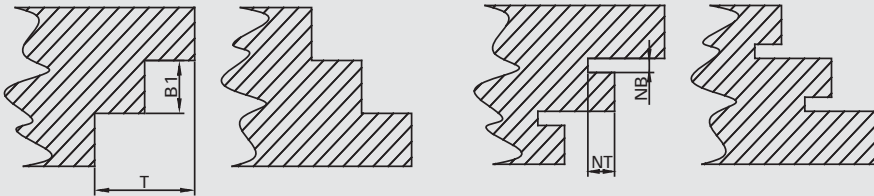
Drawing


LEUCO
CNC

tungsten carbide [HW]

MEC

Application example



Machine / Application

| CNC routers
 | for jointing and rabbeting in solid woods and wood-based panels

Design

| number of teeth Z = 3
 | with shear angle
 | body made of aluminum
 | n max = 11,700 min-1

Advantages

Notes

| to be used with corresponding shank adapters and in combination with other Modula cutterheads
 | optionally grooving knives can be used
 | wrenches are not included in delivery
 | mounting-set Ident-No. 198948

Ø D	B	b	Ø d	Tmax	Z	Ident-No.
140	48	35.6	25	47	3+6+6V	9205912
140	38	25.6	25	47	3+6+6V	9205913
[mm]	[mm]	[mm]	[mm]	[mm]		

Grooving Knives	B	Tmax	Class-No.	Ident-No.
grooving knife top/bottom	4	8	150512	879869
grooving knife top	5	8	150512	888747
grooving knife bottom	5	8	150512	888748
	[mm]	[mm]		

Spare parts

Dimension

Class-No.

Ident-No.

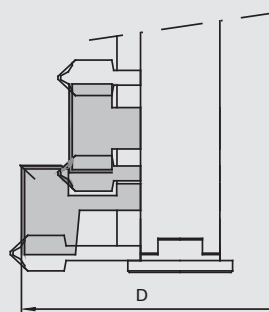
Countersunk Flat Headed Screws	for grooving knives	M5x11 T20 [mm]	995125	879871
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128660

Modula Door Rabbeting Sets HW

Product

Drawing

LEUCO
CNC

tungsten carbide [HW]

MEC

Machine / Application

| CNC routers
 | for the production of door
 rabbets

Design

| with shear angle
 | basis number of wings Z=2
 | Ø 100 mm: n max = 14,500
 min-1
 | unchanging zero-point

Advantages

| high flexibility thanks to modular
 design
 | simple adjustment by means of
 rings

Notes

| when running variable door
 production the single rebate
 edge is done with bottom
 cutter in a second pass
 | expandable by chamfering,
 concave or radius cutterheads
 | wrenches are not included in
 delivery
 | mounting-set Ident-
 No. 198948
 | please order shank-tool holder
 separately

Ø D	B1	B2	Ø d	Tmax	Z	Ident-No.
96	15-28	14-18	25	13	2	199722
96	15-28	24-38	25	13	2	199723
96	22-38	24-38	25	13	2	199724
100	15-28	14-28	25	15	2	199725
100	15-28	24-38	25	15	2	199726
100	22-38	24-38	25	15	2	199727
[mm]	[mm]	[mm]	[mm]	[mm]		

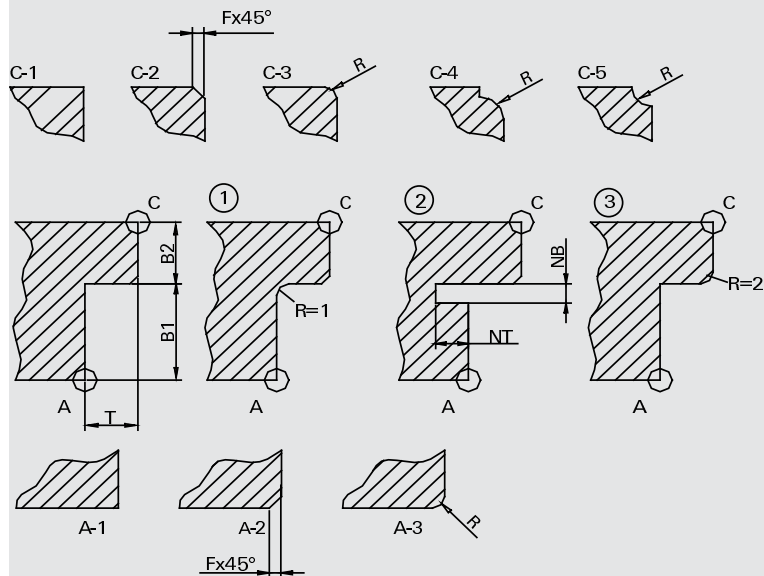
Options1	R	B	H	S	Class-No.	Ident-No.
Radius Spurs	1	13	15	2	150552	888476
	[mm]	[mm]	[mm]	[mm]		

Grooving Knives	B	Tmax	Class-No.	Ident-No.
	4	8	150512	879869
	5	8	150512	888747
	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Countersunk Flat Headed Screws for grooving knife	M5x11 T20	995125	879871
	[mm]		

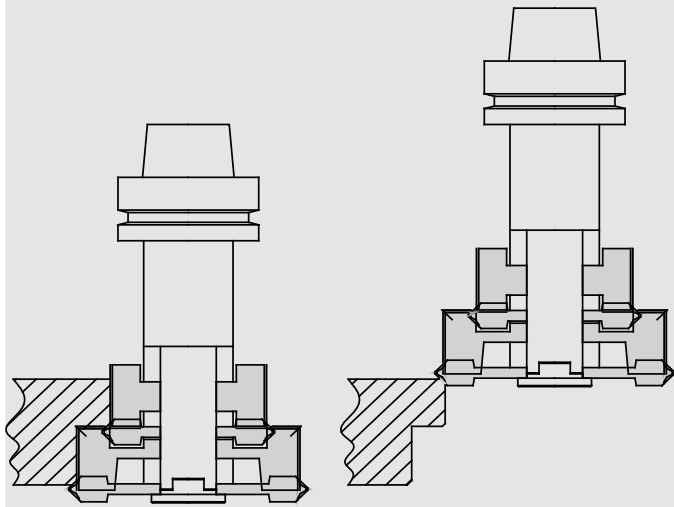
Options2	R	Chamfer	Tmax	Cutterhead	Class-No.	Ident-No.
A-2		45	13	E	120610	888737
A-3	2		13	E	120610	888738
A-3	3		13	E	120610	888739
A-2		45	15	A	120610	879845
A-3	2		15	A	120660	881168
A-3	3		15	A	120660	881169
C-2		45		B	120610	879830
C-3	2			B	120610	881166
C-3/4	3			B	120610	881167
C-3	4			F-1	120610	879984
C-3	5			F-1	120610	881170
C-3/4	6			F-1	120610	881171
C-3	8			U-1	120610	881880
	[mm]	[°]	[mm]			

Options2	R	Chamfer	Tmax	Cutterhead	Class-No.	Ident-No.
C-3/4	10			U-1	120610	881881
C-5	3			N	120610	879859
C-5	4			N	120610	881164
C-5	5			K	120610	879858
C-5	6			K	120610	881165
	[mm]	[°]	[mm]			



Modula Door Set Application

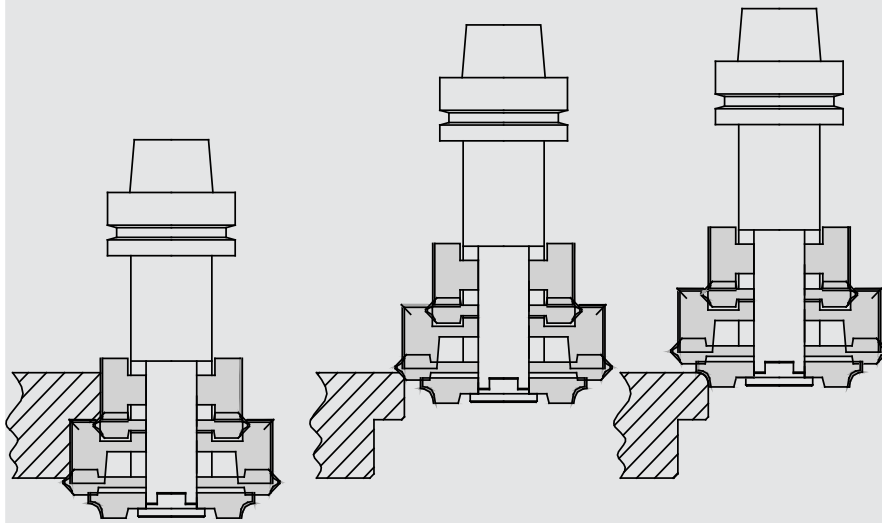
application example for different door thicknesses
profile is done in two passes



1 nd Operation

2 nd Operation

Application example with add-on cutterheads for individual doors



1 nd Operation

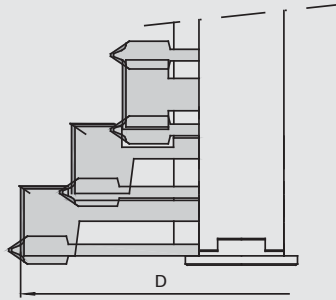
2. 2. Pass chamfer, rounding or top
of rodshape can be controlled via the
program

128660

Modula Double Rabbeting Sets HW

Product

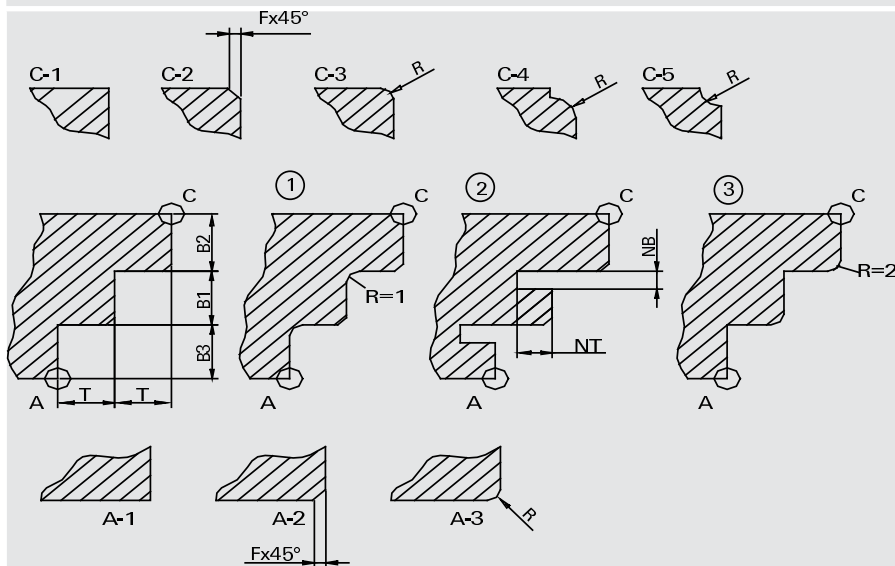
Drawing

LEUCO
CNC

tungsten carbide [HW]

MEC

Application example



Machine / Application

| CNC routers
 | for the production of door
 rabbets

Design

| with shear angle
 | basis number of wings $Z=2$
 | unchanging zero-point
 | $n_{max} = 11,500 \text{ min}^{-1}$

Advantages

| high flexibility thanks to modular
 design
 | simple adjustment by means of
 rings

Notes

| expandable by chamfering,
 concave or radius cutterheads
 | standard sets: edges A and C
 are angular
 | wrenches are not included in
 delivery
 | mounting-set Ident-
 No.198948
 | please order shank-tool holder
 separately

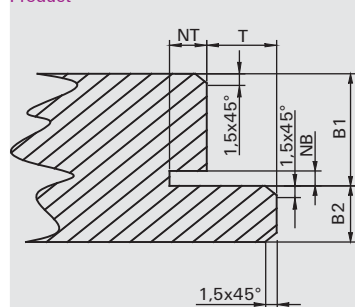
Ø D	B1	B2	B3	Ø d	Tmax			Ident-No.	
130	15-28	15-28	14-28	25	15	H-1, B, T-3, A, T-5			199781
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]				
Options1				R	B	H	S	Class-No.	Ident-No.
Radius Spurs				1	13	15	2	150552	888476
				[mm]	[mm]	[mm]	[mm]		
Options2			B	Tmax				Class-No.	Ident-No.
Grooving Knives			4	8				150512	879869
Grooving Knives			5	8				150512	888747
			[mm]	[mm]					
Spare parts					Dimension			Class-No.	Ident-No.
Countersunk Flat Headed Screws			for grooving knife		M5x11 T20			995125	879871
					[mm]				

Options	R	Chamfer $\angle$	Cutterhead	Class-No.	Ident-No.
A-2		45	Y	120610	880580
A-3	2		Y	120660	880581
A-3	3		Y	120660	880582
C-2		45	B	120610	879830
C-3	2		B	120610	881166
C-3/4	3		B	120610	881167
C-3	4		F-1	120610	879984
C-3	5		F-1	120610	881170
C-3/4	6		F-1	120610	881171
C-3	8		U-1	120610	881880
C-3/4	10		U-1	120610	881881
C-5	3		N	120610	879859
C-5	4		N	120610	881164
C-5	5		K	120610	879858
C-5	6		K	120610	881165
	[mm]	[°]			

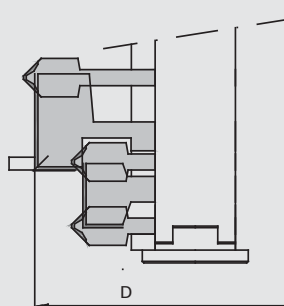
128660

Modula Door Frame Rabbeting Sets HW with chamfer

Product



Drawing

LEUCO
CNC

tungsten carbide [HW]

MEC

Machine / Application

| CNC routers
 | for the production of frame rabbets

Design

| set with chamfered edges and groove 4 x 8 mm
 | with shear angle
 | basis number of wings Z=2
 | Ø 100 mm: n max = 14,500 min-1

Advantages

| high flexibility thanks to modular design
 | simple adjustment by means of rings

Notes

| available also in counter-clockwise rotation or for rabbeting from below
 | wrenches are not included in delivery
 | mounting-set Ident-No. 198948
 | please order shank-tool holder separately

Ø D	B1	B2	Ø d	Tmax		Ident-No.
96	15-30	8-20	25	13	C-2, 2xB, T-2, E	199747
96	22-40	14-30	25	13	H-2, 2xB, T-7, E	199746
100	15-30	8-20	25	15	C-2, 2xB, T-4, A	199745
100	22-40	14-30	25	15	H-2, 2xB, T-9, A	199748
[mm]	[mm]	[mm]	[mm]	[mm]		

Grooving Knives	B	Tmax	Class-No.	Ident-No.
	4	8	150512	879869
	5	8	150512	888747
	[mm]	[mm]		

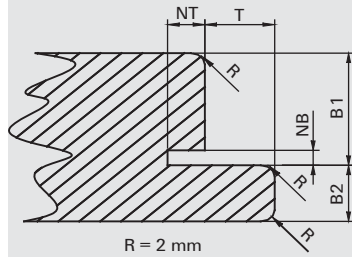
Spare parts	Dimension	Class-No.	Ident-No.
Countersunk Flat Headed Screws for grooving knife	M5x11 T20 [mm]	995125	879871

128660

Modula Door Frame Rabbeting Sets HW with radius

Product

Drawing


LEUCO
CNC

tungsten carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for the production of frame rabbets

Design

- | set with rounded edges and groove 4 x 8 mm
- | with shear angle
- | basis number of wings Z=2
- | Ø 100 mm: n max = 14,500 min-1

Advantages

- | high flexibility thanks to modular design
- | simple adjustment by means of rings

Notes

- | available also in counter-clockwise rotation or for rabbeting from below
- | wrenches are not included in delivery
- | mounting-set Ident-No. 198948
- | please order shank-tool holder separately

Ø D	B1	B2	Ø d	Tmax		Ident-No.
96	15-30	8-20	25	13	C-2, 2xB, T-2, E	199777
96	22-40	14-30	25	13	H-2, 2xB, T-7, E	199778
100	15-30	8-20	25	15	C-2, 2xB, T-4, A	199779
100	22-40	14-30	25	15	H-2, 2xB, T-9, A	199780
[mm]	[mm]	[mm]	[mm]	[mm]		

Grooving Knives	B	Tmax	Class-No.	Ident-No.
	4	8	150512	879869
	5	8	150512	888747
	[mm]	[mm]		

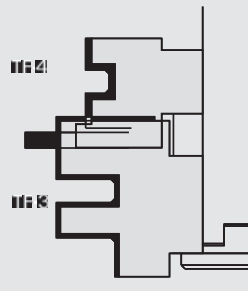
Spare parts	Dimension	Class-No.	Ident-No.
Countersunk Flat Headed Screws for grooving knife	M5x11 T20 [mm]	995125	879871

128660

Modula Door Case Sets HW

Product

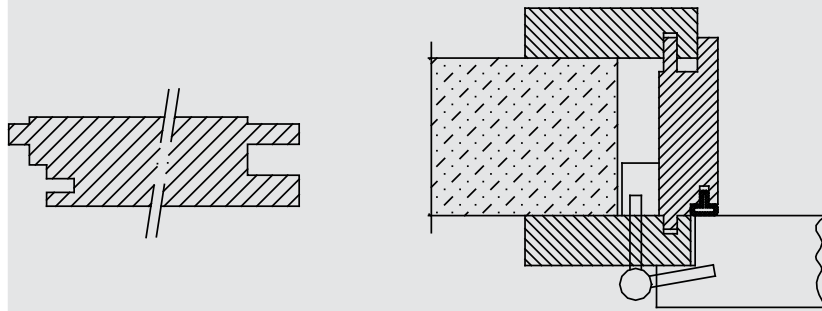
Drawing

LEUCO
CNC

tungsten carbide [HW]

MEC

Application example



Machine / Application

| CNC routers
 | for the production of door leafs
 made from solid wood and
 wood-based panels

Design

| basis number of wings Z=2
 | n max = 14,500 min-1

Advantages

| high flexibility thanks to modular
 design
 | simple adjustment by means of
 rings

Notes

| machining of both sides with
 same set
 | cutter set for one-sided
 operation upon request
 | wrenches are not included in
 delivery
 | mounting-set Ident-
 No.198948
 | please order shank-tool holder
 separately

Ø D	B1	Ø d	Tmax		Ident-No.
100 [mm]	25-30 [mm]	25 [mm]	15 [mm]	TF-3, TF-4	9202895

Turnover Knives	B	H	S	Cutterhead	Class-No.	Ident-No.
Profile Turnover Knives	10	13.5	1.5	up to 2006	151556	888963
Profile Turnover Knives	22,3	18	2	TF-4	151556	885906
Profile Turnover Knives	41	28.2	2	TF-3	151556	9202581
	[mm]	[mm]	[mm]			

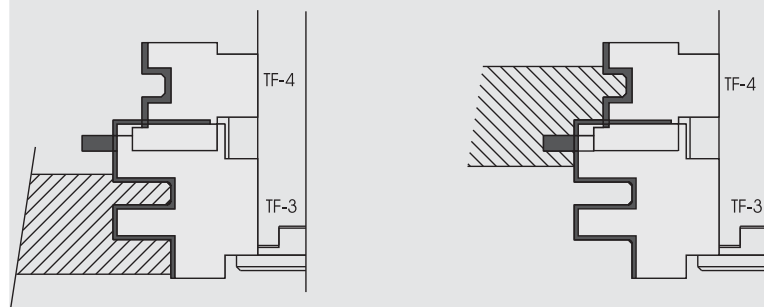
Grooving Knives	B	Tmax	Class-No.	Ident-No.
	4	13	150512	881180
	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Countersunk Flat Headed Screws	M5x11 T20	995125	879871
	[mm]		

Modula Door Set Application

Application example with standard tool

Profile is done in two passes

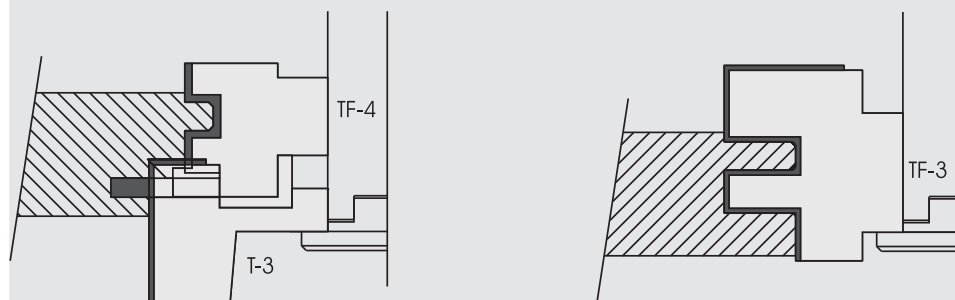


1 nd Operation

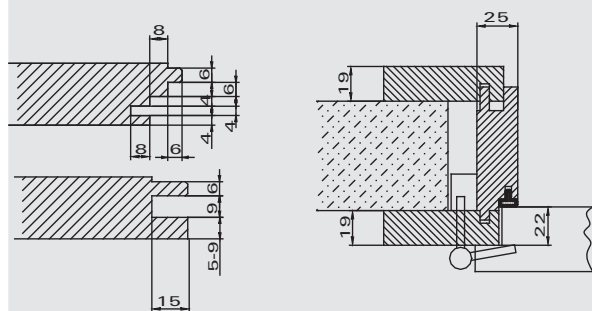
2 nd Operation

application example if cutting height is too small for the standard solution

2 tools are used



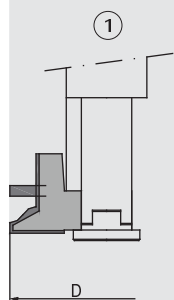
dimensions



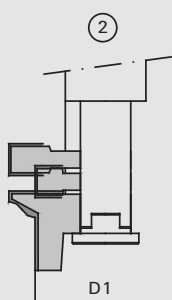
128660

Modula Counterprofile Sets HW - one-sided

Product



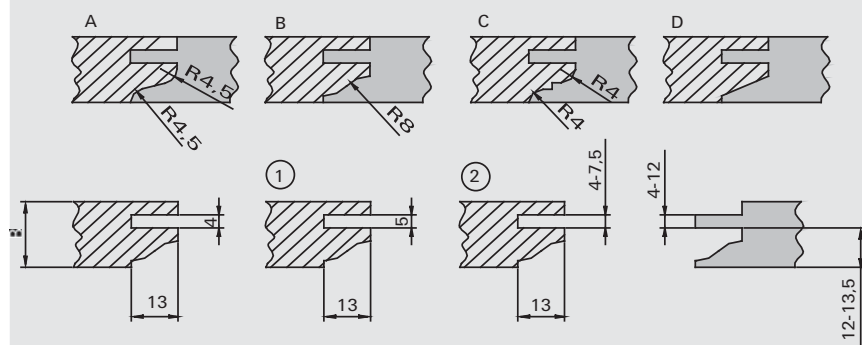
Drawing

LEUCO
CNC

tungsten carbide [HW]

MEC

Application example



Machine / Application

l CNC routers
l for length- and counterprofiles
on furniture parts, i.e. furniture
doors and cassettes

Design

l basis number of wings Z=2
l Ø 100 mm: n max = 14,500
min-1

Advantages

l 4 profiles in the same body
l complete machining in one pass

Notes

l standard delivery with profile
B, groove 4 x 13 mm
l optionally groove 5 x 13 mm
or adjustable 4 - 7.5 x 13 mm
l available for clockwise and
counter-clockwise rotation
l wrenches are not included in
delivery
l mounting-set Ident-
No. 198948
l please order shank-tool holder
separately

Ø D	Ø D1	B	Ø d	Type	Ident-No.
96	70	20-27	25	1 X-2, groove 4	199775
96	70	20-27	25	2 X-1, G, W	199776
[mm]	[mm]	[mm]	[mm]		

Options1	B	Tmax	Class-No.	Ident-No.
Grooving Knives	5	13	150512	879870
	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Countersunk Flat Headed Screws for grooving knife	M5x11 T20	995125	879871
	[mm]		

Options2	B	Tmax	Class-No.	Ident-No.
cutter Q	4	13	120200	881153
	[mm]	[mm]		

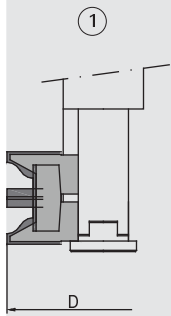
Knives	B	H	S	Cutterhead	Class-No.	Ident-No.
profile A left	30	26	2	X-1	151521	882465
profile A right	30	26	2	X-2	151522	882466
profile B left	30	26	2	X-1	151521	882463
	[mm]	[mm]	[mm]			

Knives	B	H	S	Cutterhead	Class-No.	Ident-No.
profile B right	30	26	2	X-2	151522	882464
profile C left	30	26	2	X-1	151521	882461
profile C right	30	26	2	X-2	151522	882462
profile D left	30	26	2	X-1	151521	882467
profile D right	30	26	2	X-2	151522	882468
	[mm]	[mm]	[mm]			

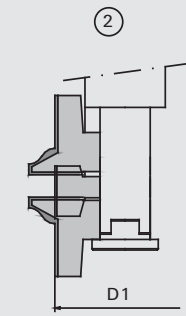
128660

Modula Counterprofile Sets HW - double-sided

Product



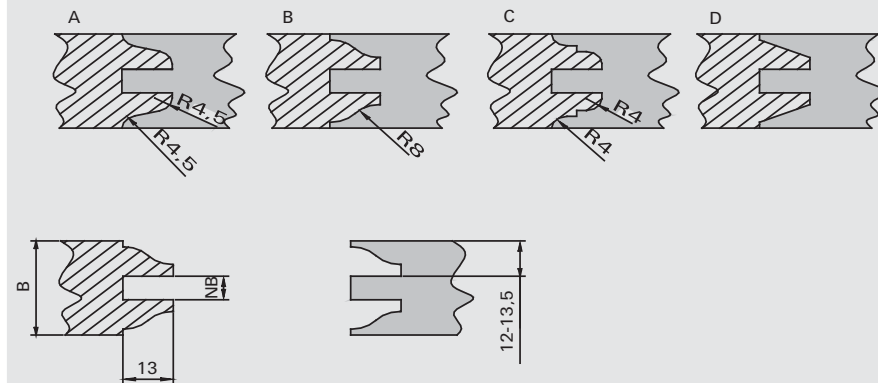
Drawing


LEUCO
CNC

tungsten carbide [HW]

MEC

Application example



Machine / Application

| CNC routers
 | for length- and counterprofiles
 on furniture parts, e.g. doors

Design

| basis number of wings $Z=2$
 | $\varnothing 100$ mm: $n \max = 14,500$
 min-1

Advantages

| 4 profiles in the same body
 | complete machining in one pass

Notes

| standard delivery with profile B, groove 8 - 15 x 13 mm
 | optionally groove 5 - 9,5 x 13 mm possible
 | available for clockwise and counter-clockwise rotation
 | wrenches are not included in delivery
 | mounting-set Ident-No. 198948
 | please order shank-tool holder separately

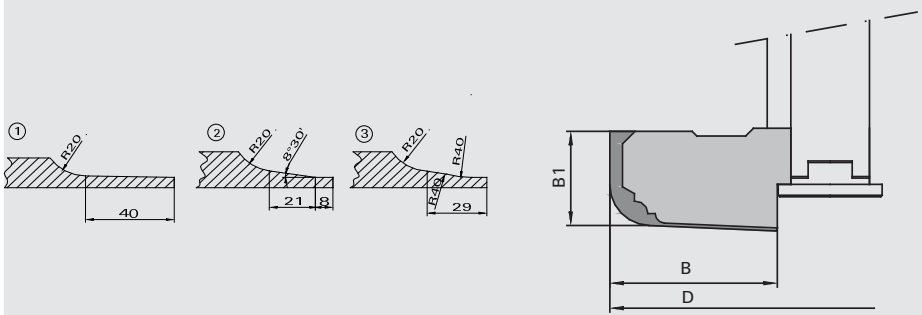
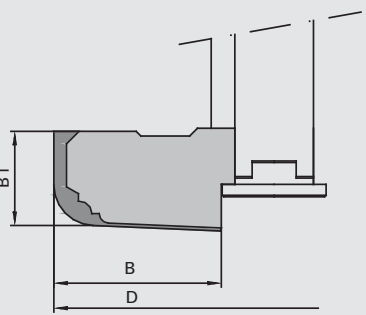
$\varnothing D$	$\varnothing D1$	B	$\varnothing d$	Type		Ident-No.
96	70	34-42	25	1	X-1, X-2	199389
96	70	34-42	25	2	X-1, C-1, X-2	199390
[mm]	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	Cutterhead	Class-No.	Ident-No.
Turnover Knives	20	12	1.5	C	150515	003082
	[mm]	[mm]	[mm]			

Grooving Knives	B	Tmax	Cutterhead	Class-No.	Ident-No.	
	8	13	X-1	150512	882483	
	8	13	X-2	150512	882460	
	5	13	X-1, X-2	150512	879870	
	[mm]	[mm]				
Spare parts	Dimension			Class-No.	Ident-No.	
Countersunk Flat Headed Screws for grooving knife	M5x11 T20			995125	879871	
	[mm]					
Knives	B	H	S	Cutterhead	Class-No.	Ident-No.
profile A left	30	26	2	X-1	151521	882465
profile A right	30	26	2	X-2	151522	882466
profile B left	30	26	2	X-1	151521	882463
profile B right	30	26	2	X-2	151522	882464
profile C left	30	26	2	X-1	151521	882461
profile C right	30	26	2	X-2	151522	882462
profile D left	30	26	2	X-1	151521	882467
profile D right	30	26	2	X-2	151522	882468
	[mm]	[mm]	[mm]			

128660

Modula Panel Raising Cutterheads HW

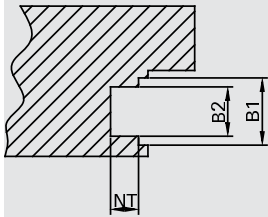
Product	Drawing				
					
			tungsten carbide [HW]		
			MEC		
Machine / Application	Design		Advantages		Notes
- CNC routers - for panel raising and profiling in solid woods and wood-based panels	- basis number of wings Z=2 - Ø 140 mm: n max = 9,000 min-1				- further profiles are possible according to customer specifications - wrenches are not included in delivery - mounting-set Ident-No. 198948 - please order shank-tool holder separately

R	Ø D	B	B1	Ø d		
20	140	55	30	25	888504	
[mm]	[mm]	[mm]	[mm]	[mm]		
Knives for bottom cutting edge				B	H	S
				48	12	1.5
				[mm]	[mm]	[mm]
Knives for peripheral cutting edge				R	B	H
				20	30	25
				[mm]	[mm]	[mm]
Support plate for peripheral cutting edge				R	B	H
				20	30	25
				[mm]	[mm]	[mm]

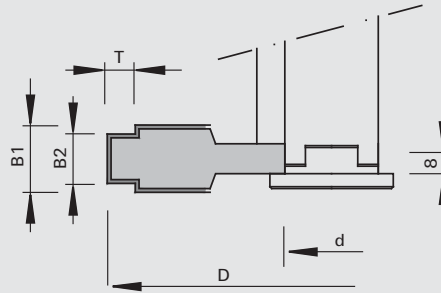
128660

Modula Step Grooving Cutterheads HW

Product



Drawing


LEUCO
CNC

tungsten carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for grooving of notches in solid woods and wood-based panels for safety-locks and fittings

Design

- | basis number of wings $Z=2$
- | $n \text{ max} = 12,000 \text{ min}^{-1}$

Advantages

- | less chipping thanks to divided cut

Notes

- | application against feed
- | step groove for 18 and 20 mm possible with same cutter body by changing of profile knives
- | can be combined with other Modula cutterheads
- | wrenches are not included in delivery
- | Mounting Set Ident-No. 198948
- | please order shank tool holder separately

Ø D	B1	B2	Ø d	Tmax	Type	Ident-No.
120	18,1	13,2	25	7,5	R	879990
120	20,1	15,2	25	7,5	R	881190
[mm]	[mm]	[mm]	[mm]	[mm]		

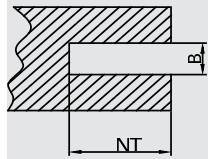
Knives	B	B1	H	S	Class-No.	Ident-No.
	18,1	13,2	20	2	150515	881106
	20,1	15,2	20	2	150515	881183
	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Set Screws	M5x10	995161	881087
Clamping Bars	B=18	925300	881105
Magnetic Stops	1,0	997800	166094
	[mm]		

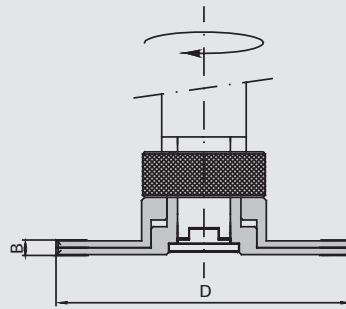
128660

Modula Grooving Cutterheads HW

Product



Drawing

LEUCO
CNC

tungsten carbide [HW]

MEC

Machine / Application

l CNC routers
l for grooving in solid woods and wood-based panels

Design

l basis number of wings Z=2
l n max = 11,000 min-1

Advantages

l unique adjusting unit with threaded bush

Notes

l play-free adjustment thanks to setting ring gauge
l fine-adjustment scale with 0,1 mm increments
l wrenches are not included in delivery
l mounting-set Ident-No. 198948
l please order shank-tool holder separately

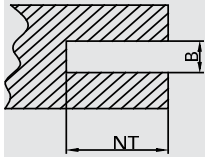
Ø D	B	Ø d	Tmax	Z		Ident-No.
140	4-7,5	25	40	4+4+4	with spurs	889645
140	7,5-11	25	40	4+2+4	with spurs	889876
150	10-18	25	45	2+2+4	with spurs	9201087
[mm]	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	For Ident-No.	Class-No.	Ident-No.
Turnover Knives	9	12	1.5	889876	150515	167256
Turnover Knives	9,6	12	1.5	9201087	150515	171163
Turnover Knives	7,6	12	1.5	889876, 889645	150515	052543
Spurs	14	14	1.2	889876, 889645	150559	163701
Spurs	14	14	2	9201087	150559	003079
	[mm]	[mm]	[mm]			

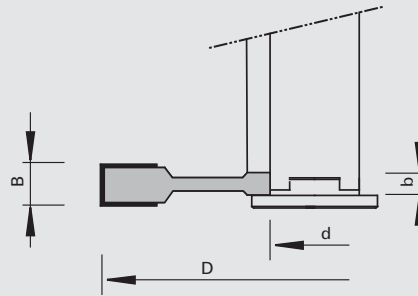
128660

Modula Planet Cutterheads HW

Product



Drawing


LEUCO
CNC

tungsten carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for grooving of notches in solid woods and wood-based panels for fittings and drop-down seals (Planet) on doors

Design

- | number of teeth $Z = 3 + 3$
- | $n_{max} = 10,100 \text{ min}^{-1}$

Advantages

- | reduced cutting pressure and less chipping thanks to division of cut

Notes

- | application with feed
- | mountable lefthand or righthand
- | can be combined with other Modula cutterheads
- | wrenches are not included in delivery
- | Mounting Set Ident-No. 198948
- | please order shank tool holder separately

Ø D	B	b	Ø d	Z	Type	Ident-No.
150	13,1	7	25	3+3	I	9206343
[mm]	[mm]	[mm]	[mm]			

Knives	B	H	S	Class-No.	Ident-No.
	7	12	1.5	until 1999	150515 881453
	9	12	1.5	from 2000	150515 167256
	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Set Screws	M5x10	995161	881087
Clamping Bars	B=7,2	925100	870829
Magnetic Stops	1,0	997800	166094
	[mm]		

120210

Modula Single Jointing/Rabbeting Cutterheads HW - Z=2

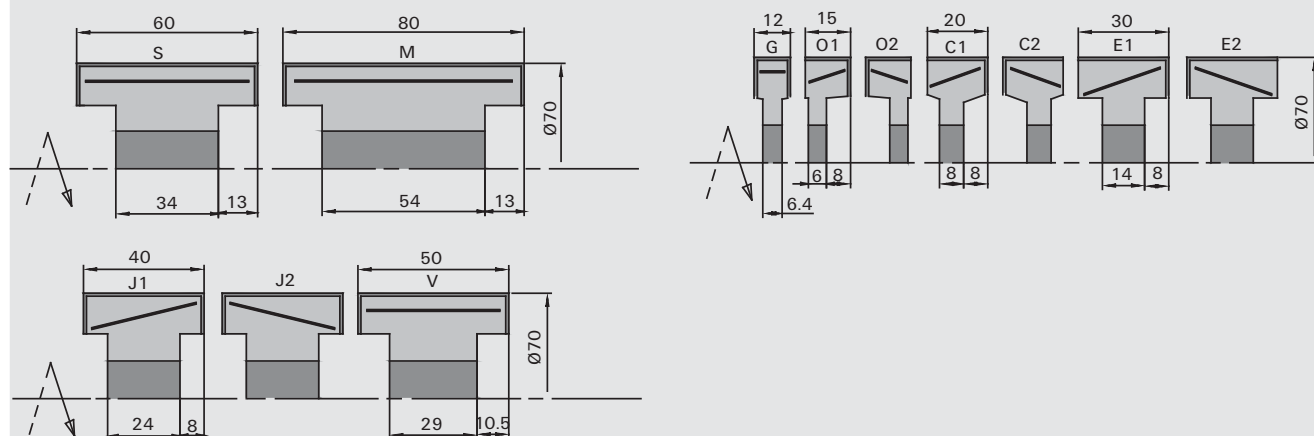
Product

Drawing

LEUCO
CNC

tungsten carbide [HW]

MEC



Machine / Application

| CNC routers
 | for jointing and rabbeting in
 solid woods and wood-based
 panels

Design

| cutterheads with B = 15 mm to
 40 mm with shear angle
 | number of teeth Z = 2
 | n max = 14,500 min-1

Advantages

Notes

| to be used with correspon-
 ding shank adapters and
 in combination with other
 Modula cutterheads
 | wrenches are not included in
 delivery
 | mounting-set Ident-
 No. 198948

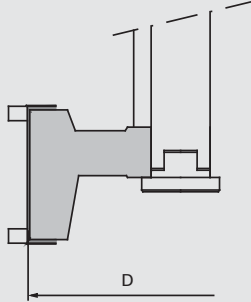
Ø D	B	b	Ø d	Z	Type	Ident-No.
70	12	6.4	25	2	G	879829
70	15	6	25	2	O-1	879828
70	15	6	25	2	O-2	879833
70	20	8	25	2	C-1	879827
70	20	8	25	2	C-2	879832
70	30	14	25	2	H-1	879854
70	30	14	25	2	H-2	879855
70	40	24	25	2	J-1	882012
70	40	24	25	2	J-2	882013
70	50	29	25	2	V	9201908
70	60	34	25	2	S	888526
70	80	54	25	2	M	888527
[mm]	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	Cutterhead	Class-No.	Ident-No.
Turnover Knives	12	12	1.5	G	150515	003080
Turnover Knives	15	12	1.5	O-1, O-2	150515	003081
Turnover Knives	20	12	1.5	C-1, C-2	150515	003082
Turnover Knives	30	12	1.5	H-1, H-2	150515	003083
Turnover Knives	40	12	1.5	J-1, J-2	150515	164078
Turnover Knives	50	12	1.5	V	150515	003085
	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	Cutterhead	Class-No.	Ident-No.
Turnover Knives	60	12	1.5	S	150515	003086
Turnover Knives	80	12	1.5	M	150512	888545
	[mm]	[mm]	[mm]			
Spare parts	Dimension		Cutterhead		Class-No.	Ident-No.
Set Screws	M5x10				995161	881087
Clamping Bars	B=10		G, O-1, O-2		925300	164526
Clamping Bars	B=18		C-1, C-2		925300	164076
Clamping Bars	B=30		H-1, H-2		925300	164185
Clamping Bars	B=40		J-1, J-2		925300	882014
Clamping Bars	B=50		V		925300	883382
Clamping Bars	B=60		S		925300	888543
Clamping Bars	B=80		M		925300	888544
Magnetic Stops	1,0				997800	166094
	[mm]					

120210

Modula Single Rabbeting Cutterheads HW - Z=3

Product	Drawing		
		LEUCO CNC	tungsten carbide [HW]
			MEC
Machine / Application	Design	Advantages	Notes
- CNC routers - for jointing and rabbeting in solid woods and wood-based panels	- number of teeth Z = 3 - with shear angle - body made of aluminum - n max = 11,700 min-1		- to be used with corresponding shank adapters and in combination with other Modula cutterheads - optionally grooving knives can be used - wrenches are not included in delivery - mounting-set Ident-No. 198948

Ø D	B	b	Ø d	Tmax	Z	Ident-No.
140	48	35.6	25	47	3+6+6V	9205912
140	38	25.6	25	47	3+6+6V	9205913
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
Spurs	14	14	2	150559	003079
Turnover Knives	39,2	12	1.5	150515	9203225
Turnover Knives	49,2	12	1.5	150515	9203226
Grooving Knives	4	8		150512	879869
Grooving Knives	4	13		150512	881180
Grooving Knives	5	8		150512	888747
Grooving Knives	5	8		150512	888748
Grooving Knives	5	13		150512	888749
Grooving Knives	5	13		150512	888750
	[mm]	[mm]	[mm]		

Spare parts		Dimension	For Ident-No.	Class-No.	Ident-No.
Countersunk Flat Headed Screws	for grooving knives	M5x11 T20		995125	879871
Countersunk Flat Headed Screws	for spurs	M5x7 T15		995125	900512
set screws		M6x20		995161	9204674
Pressure Jaws		B=38	9205913	925300	9205914
Pressure Jaws		B=48	9205912	925300	9201835
		[mm]			

120210

Modula Single Rabbeting Cutterheads HW - Z=2

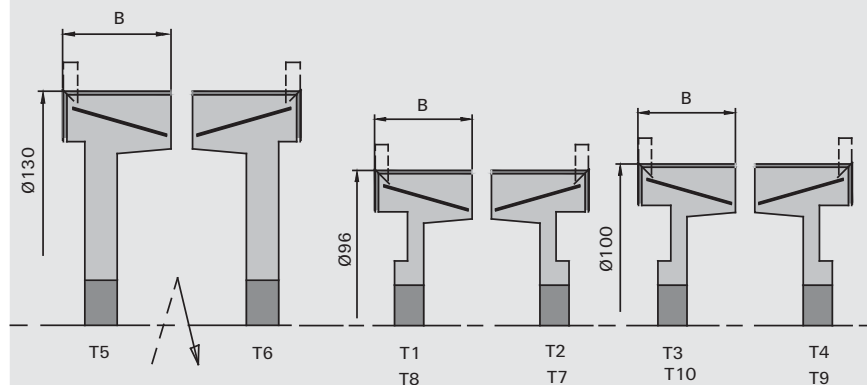
Product

Drawing

LEUCO
CNC

tungsten carbide [HW]

MEC



Machine / Application

| CNC routers
 | for jointing and rabbeting in solid woods and wood-based panels

Design

| number of teeth $Z = 2$
 | with shear angle
 | Ø 100 mm: n max = 14,500 min-1
 | Ø 130 mm: n max = 11,500 min-1

Advantages

Notes

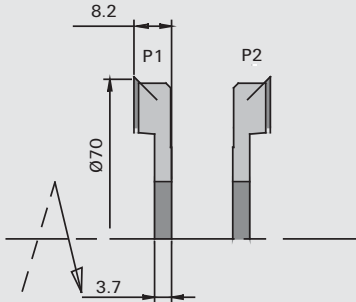
| to be used with corresponding shank adapters and in combination with other Modula cutterheads
 | wrenches are not included in delivery
 | mounting-set Ident-No. 198948

Ø D	B	b	Ø d	Z	Type	Ident-No.
96	30	9	25	2+2V	T-1	888467
96	30	9	25	2+2V	T-2	888466
96	40	15.5	25	2+2V	T-8	889427
96	40	15.5	25	2+2V	T-7	889426
100	30	9	25	2+2V	T-3	888524
100	30	9	25	2+2V	T-4	888523
100	40	15.5	25	2+2V	T-10	889429
100	40	15.5	25	2+2V	T-9	889428
130	30	9	25	2+2V	T-5	888525
130	30	9	25	2+2V	T-6	888522
[mm]	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	Cutterhead	Class-No.	Ident-No.
Spurs	14	14	2	T-3	150559	003079
Turnover Knives	30	12	1.5	T-1 to T-6	150515	003083
Turnover Knives	40	12	1.5	T-7 to T-10	150515	164078
Grooving Knives	4	8			150512	879869
Grooving Knives	4	13			150512	881180
Grooving Knives	5	8		T-1, T-3, T-5, T-8, T-10	150512	888747
Grooving Knives	5	8		T-2, T-4, T-6, T-7, T-9	150512	888748
Grooving Knives	5	13		T-1, T-3, T-5, T-8, T-10	150512	888749
Grooving Knives	5	13		T-2, T-4, T-6, T-7, T-9	150512	888750
	[mm]	[mm]	[mm]			
Spare parts			Dimension		Class-No.	Ident-No.
Countersunk Flat Headed Screws	for grooving knife		M5x11 T20		995125	879871
Countersunk Flat Headed Screws	for spur		M5x7 T15		995125	900512
Set Screws			M5x10		995161	881087
Clamping Bars			B=30		925300	164185
Clamping Bars			B=40		925300	882014
Magnetic Stops			1,0		997800	166094
			[mm]			

120200

Modula Single Pre-Cut Cutterheads HW

Product	Drawing			
			LEUCO CNC tungsten carbide [HW] MEC	
Machine / Application	Design	Advantages	Notes	
- CNC routers - for scoring in solid woods and wood-based panels	- number of teeth $Z = 2$ $n_{max} = 14,500 \text{ min}^{-1}$		- to be used with corresponding shank adapters and in combination with other Modula cutterheads - wrenches are not included in delivery - mounting-set Ident-No. 198948	

Ø D	B	b	Ø d	Z	Type	Ident-No.
70	8,2	3.7	25	2+2V	P-1	879831
70	8,2	3.7	25	2+2V	P-2	879834
[mm]	[mm]	[mm]	[mm]			

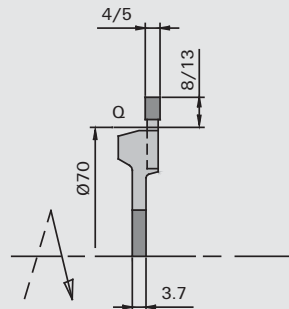
Turnover Knives	B	H	S	Class-No.	Ident-No.
Spurs	14	14	2	150559	003079
Radius Spurs	13	15	2	150552	888476
	[mm]	[mm]	[mm]		
Spare parts	Dimension			Class-No.	Ident-No.
Countersunk Flat Headed Screws	M5x7 T15			995125	900512
	[mm]				

120200

Modula Single Grooving Cutterheads HW

Product

Drawing

LEUCO
CNC

tungsten carbide [HW]

MEC

Machine / Application

Design

Advantages

Notes

| CNC routers
 | for grooving in solid woods and wood-based panels

| number of teeth $Z = 2$
 | $n_{max} = 14,500 \text{ min}^{-1}$

| to be used with corresponding shank adapters and in combination with other Modula cutterheads
 | wrenches are not included in delivery
 | mounting-set Ident-No. 198948

Ø D	B	Ø d	Tmax	Z	Type	Ident-No.
70	4	25	8	2	Q	879835
70	4	25	13	2	Q	881153
70	5	25	8	2	Q	881154
70	5	25	13	2	Q	881155
[mm]	[mm]	[mm]	[mm]			

Grooving Knives	B	Tmax	Class-No.	Ident-No.
	4	13	150512	881180
	4	8	150512	879869
	5	13	150512	879870
	5	8	150512	881179
	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Countersunk Flat Headed Screws for grooving knife	M5x11 T20	995125	879871
	[mm]		

120610

Modula Single Chamfering Cutterheads HW

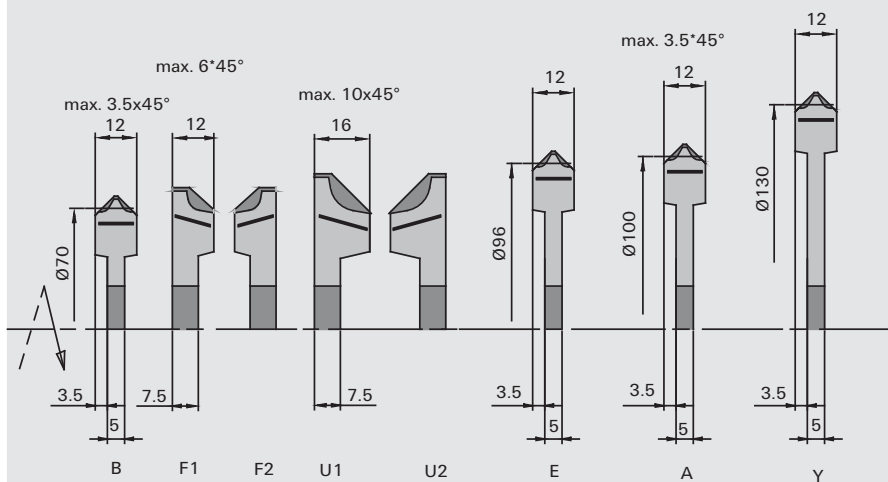
Product

Drawing

LEUCO
CNC

tungsten carbide [HW]

MEC



Machine / Application

l CNC routers
l for chamfering in solid woods
and wood-based panels

Design

l number of teeth $Z = 2$
l $\varnothing 108 \text{ mm}$: $n \text{ max} = 14,500$
min-1
l $\varnothing 138 \text{ mm}$: $n \text{ max} = 11,500$
min-1

Advantages

Notes

l to be used with corresponding shank adapters and in combination with other Modula cutterheads
l wrenches are not included in delivery
l mounting-set Ident-No. 198948

Chamfer	$\varnothing D$	B	$\varnothing d$	Z	Type	Ident-No.
45	78	12	25	2	B	879830
45	82	12	25	2	F-1	881879
45	82	12	25	2	F-2	881878
45	90	16	25	2	U-1	881882
45	90	16	25	2	U-2	881885
45	104	12	25	2	E	888737
45	108	12	25	2	A	879845
45	138	12	25	2	Y	880580
[°]	[mm]	[mm]	[mm]			

Knives

Chamfer

B

S

Cutterhead

Class-No.

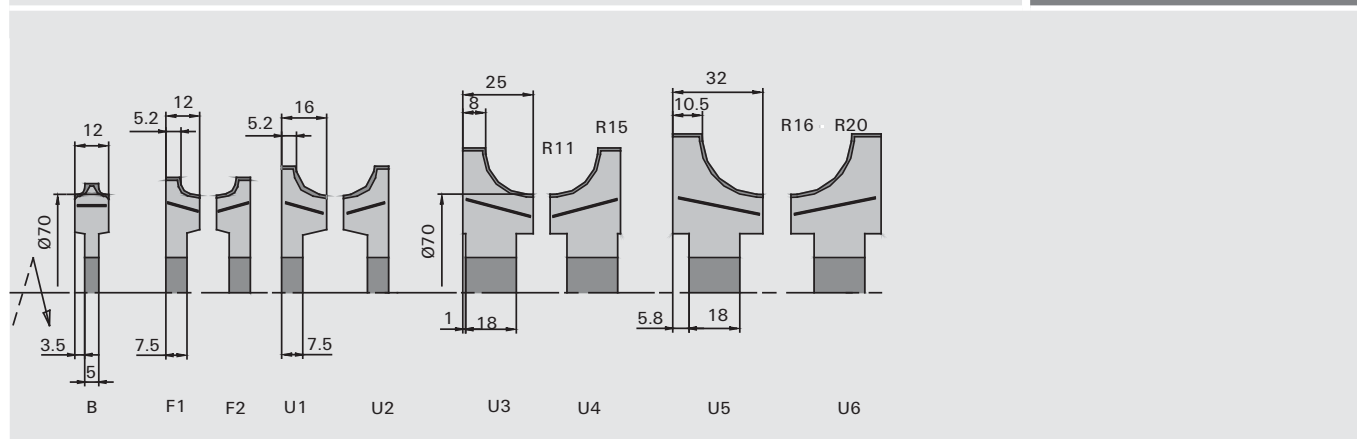
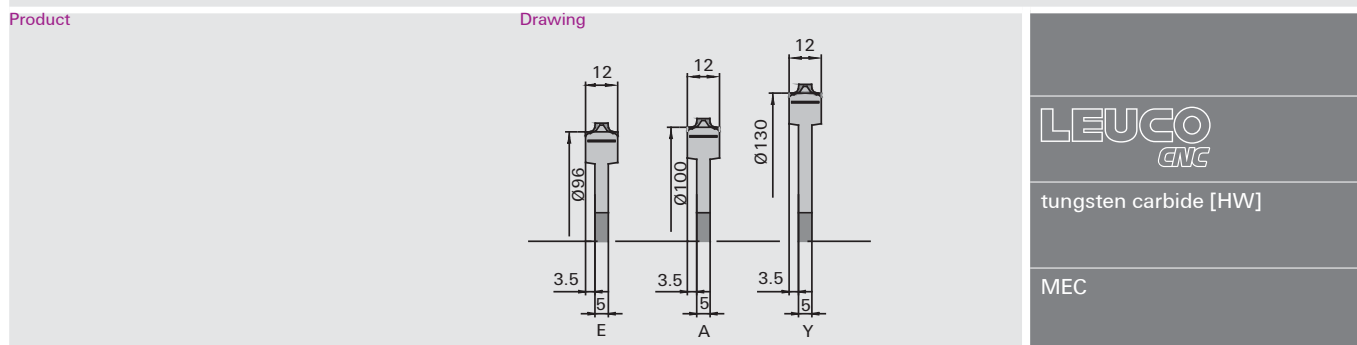
Ident-No.

45	12	1.5	A, B, E, Y	151545	180792
45	12	2	F-1	151545	881855
45	12	2	F-2	151545	881856
45	16	2	U-1	151545	881874
45	16	2	U-2	151545	881875
[°]	[mm]	[mm]			

Spare parts	Dimension	Cutterhead	Class-No.	Ident.No.
Set Screws	M5x10		995161	881087
Clamping Bars	B= 12	A, B, E, Y	925300	881496
Clamping Bars	B= 10	F-1, F-2	925300	164526
Clamping Bars	B= 16	U-1	925300	881876
Clamping Bars	B= 16	U-2	925300	881877
Magnetic Stops	0,0		997800	016613
	[mm]			

120210

Modula Single Rounding Cutterheads HW



Machine / Application	Design	Advantages	Notes
■ CNC routers ■ for rounding of solid woods and wood-based panels	■ number of teeth Z = 2 ■ Ø 108 mm: n max = 14,500 min-1 ■ Ø 138 mm: n max = 11,500 min-1		■ to be used with corresponding shank adapters and in combination with other Modula cutterheads ■ wrenches are not included in delivery ■ mounting-set Ident-No. 198948

R	Ø D	B	Ø d	Z	Type	Ident-No.
2	78	12	25	2	B	881166
3	78	12	25	2	B	881167
4	82	12	25	2	F-1	879984
4	82	12	25	2	F-2	879985
5	82	12	25	2	F-1	881170
5	82	12	25	2	F-2	881172
6	82	12	25	2	F-1	881171
6	82	12	25	2	F-2	881173
8	90	16	25	2	U-1	881880
8	90	16	25	2	U-2	881883
10	90	16	25	2	U-1	881881
10	90	16	25	2	U-2	881884
2	104	12	25	2	E	888738
3	104	12	25	2	E	888739
[mm]	[mm]	[mm]	[mm]			

R	Ø D	B	Ø d	Z	Type	Ident-No.
2	108	12	25	2	A	881168
3	108	12	25	2	A	881169
2	138	12	25	2	Y	880581
3	138	12	25	2	Y	880582
11	103	25	25	2	U-3	9202138
11	103	25	25	2	U-4	9202139
12	103	25	25	2	U-3	9202140
12	103	25	25	2	U-4	9202141
13	103	25	25	2	U-3	9202142
13	103	25	25	2	U-4	9202143
14	103	25	25	2	U-3	9202144
14	103	25	25	2	U-4	9202145
15	103	25	25	2	U-3	9202146
15	103	25	25	2	U-4	9202147
16	113	32	25	2	U-5	9202128
16	113	32	25	2	U-6	9202129
17	113	32	25	2	U-5	9202130
17	113	32	25	2	U-6	9202131
18	113	32	25	2	U-5	9202132
18	113	32	25	2	U-6	9202133
19	113	32	25	2	U-5	9202134
19	113	32	25	2	U-6	9202135
20	113	32	25	2	U-5	9202136
20	113	32	25	2	U-6	9202137
[mm]	[mm]	[mm]	[mm]			

Knives	R	B	S	Cutterhead	Class-No.	Ident-No.
	2	12	1.5	A, B, E, Y	151545	170340
	3	12	1.5	A, B, E, Y	151545	170341
	4	12	2	F-1	151545	881189
	4	12	2	F-2	151545	881188
	5	12	2	F-1	151545	881187
	5	12	2	F-2	151545	881186
	6	12	2	F-1	151545	879987
	6	12	2	F-2	151545	879988
	8	16	2	U-1	151545	881870
	8	16	2	U-2	151545	881871
	10	16	2	U-1	151545	881872
	10	16	2	U-2	151545	881873
	11	25	2	U-3	151545	9201953 o
	11	25	2	U-4	151545	9201954 o
	12	25	2	U-3	151545	9201951 o
	12	25	2	U-4	151545	9201952 o
	13	25	2	U-3	151545	9201949 o
	13	25	2	U-4	151545	9201950 o
	14	25	2	U-3	151545	9201947 o
	14	25	2	U-4	151545	9201948 o
	15	25	2	U-3	151545	9201913
	15	25	2	U-4	151545	9201914
	16	32	2	U-5	151545	9201961 o
	16	32	2	U-6	151545	9201962 o
	17	32	2	U-5	151545	9201959 o
	17	32	2	U-6	151545	9201960 o
	18	32	2	U-5	151545	9201957 o
	18	32	2	U-6	151545	9201958 o
	19	32	2	U-5	151545	9201955 o
	19	32	2	U-6	151545	9201956 o
	20	32	2	U-5	151545	9201936
	20	32	2	U-6	151545	9201937
	[mm]	[mm]	[mm]			

Spare parts	Dimension	Cutterhead	Class-No.	Ident-No.
Set Screws	M5x10		995161	881087
Clamping Bars	B=12	A, B, E, Y, F-1, F-2	925300	881496
Clamping Bars	B=16	U-1	925300	881876
Clamping Bars	B=16	U-1	925300	881877
Clamping Bars	B=25	U-3	925300	9201887
Clamping Bars	B=25	U-4	925300	9201888
Clamping Bars	B=32	U-5	925300	9201883
Clamping Bars	B=32	U-6	925300	9201884
Magnetic Stops	0,0		997800	016613
	[mm]			

120610

Modula Single Chamfering Cutterheads HW - machining of aluminum

Product	Drawing	
		tungsten carbide [HW] MEC

Machine / Application	Design	Advantages	Notes
- CNC routers - for chamfering in aluminum	- number of teeth Z = 2 - Ø 111 mm: n max = 14,500 min-1 - Ø 141 mm: n max = 11,500 min-1		- to be used with corresponding shank adapters and in combination with other Modula cutterheads - wrenches are not included in delivery - mounting-set Ident-No. 198948

Chamfer	Ø D	B	Ø d	Z	Type	Ident-No.
45	107	16	25	2	D-2	888528
45	111	16	25	2	D-4	888529
45	141	16	25	2	D-6	888530
[°]	[mm]	[mm]	[mm]			

Knives	Chamfer	B	S	Class-No.	Ident-No.
	45	16	2	151545	170329
	[°]	[mm]	[mm]		

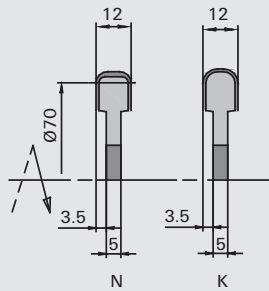
Spare parts	Dimension	Class-No.	Ident-No.
Set Screws	M5x10	995161	881087
Clamping Bars	B=16	925300	888887
Magnetic Stops	0,0	997800	016613
	[mm]		

120610

Modula Single Concave Cutterheads HW

Product

Drawing


LEUCO
CNC

tungsten carbide [HW]

MEC

Machine / Application

| CNC routers
 | for coves in solid woods and wood-based panels

Design

| number of teeth Z = 2
 | n max = 14,500 min-1

Advantages

Notes

| to be used with corresponding shank adapters and in combination with other Modula cutterheads
 | wrenches are not included in delivery
 | mounting-set Ident-No. 198948

R	Ø D	B	Ø d	Z	Type	Ident-No.
3	78	12	25	2	N	879859
4	78	12	25	2	N	881164
5	82	12	25	2	K	879858
6	82	12	25	2	K	881165
[mm]	[mm]	[mm]	[mm]			

Knives	R	B	S	Cutterhead	Class-No.	Ident-No.
	3	12	2	N	151521	881185
	4	12	2	N	151521	881184
	5	12	2	K	151521	879861
	6	12	2	K	151521	879860
	[mm]	[mm]	[mm]			

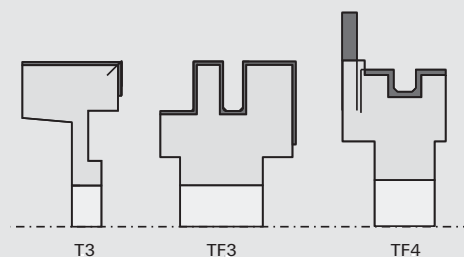
Spare parts	Dimension	Class-No.	Ident-No.
Set Screws	M5x10	995161	881087
Clamping Bars	B=12	925300	881488
Magnetic Stops	1,0	997800	166094
	[mm]		

120210

Modula Single Cutterheads HW - production of door casings

Product

Drawing

LEUCO
CNC

tungsten carbide [HW]

MEC

Machine / Application

| CNC routers
 | for door casings in solid woods
 and wood-based panels

Design

| number of teeth $Z = 2$
 | $n_{max} = 14,500 \text{ min}^{-1}$

Advantages

| machining of both sides with
the same set

Notes

| for use with corresponding
 shank adapters and in
 combination with other
 Modula cutterheads
 | wrenches are not included in
 delivery
 | Mounting Set Ident-
 No.198948
 | tools for one-sided operation
 upon request

Ø D	B	b	Ø d	Z	Type	Ident-No.
100	22	16.3	25	2	TF-4	9202564
100	41	25	25	2	TF-3	9202563
100	30	9	25	2+2V	T-3	888524
[mm]	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	For Ident-No.	Class-No.	Ident-No.
Profile Turnover Knives	22,3	18	2	TF-4	151556	885906
Profile Turnover Knives	41	28.2	2	TF-3	151556	9202581
Turnover Knives	30	12	1.5	T-1 to T-6	150515	003083
Spurs	14	14	2	T-3	150559	003079
Profile Turnover Knives	10	13.5	1.5	profile up to 2006	151556	888963
	[mm]	[mm]	[mm]			

Grooving Knives	B	Tmax	Class-No.	Ident-No.
	4	13	150512	881180
	[mm]	[mm]		

Spare parts	Dimension	Cutterhead	Class-No.	Ident-No.
Countersunk Flat Headed Screws	M5x11 T20	for grooving knife	995125	879871
Clamping Bars	B=18		925300	164076
Clamping Bars	B=40		925300	882014
Clamping Bars	B=30		925300	164185
Set Screws	M5x10		995161	881087
	[mm]			

120210

Modula Single Counter Profile Cutterheads HW

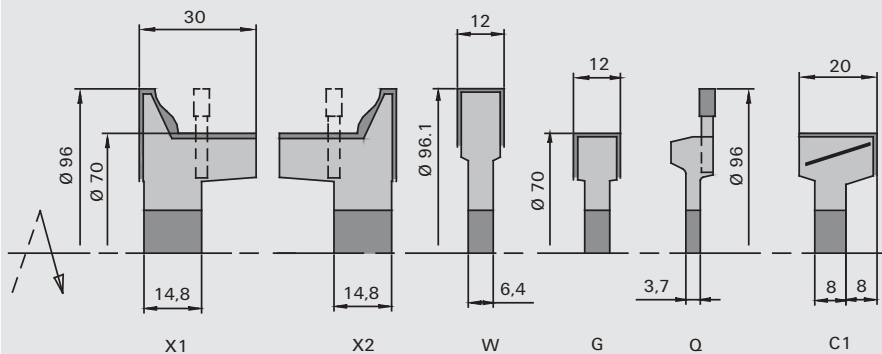
Product

Drawing

LEUCO
CNC

tungsten carbide [HW]

MEC



Machine / Application

| CNC routers
 | for length- and counterprofiles
 | in solid wood and wood-based
 | materials

Design

| number of teeth $Z = 2$
 | $n_{max} = 14,500 \text{ min}^{-1}$

Advantages

Notes

| to be used with corresponding
 | shank adapters and
 | in combination with other
 | Modula cutterheads
 | wrenches are not included in
 | delivery
 | mounting-set Ident-
 | No.198948

Ø D	B	b	Ø d	Z	Type	Ident-No.
70	20	8	25	2	C-1	879827
70	12	6.4	25	2	G	879829
70	5		25	2	Q	881155
96	12	6.4	25	2	W	882457
96	30	14.8	25	2	X-2	882458
96	30	14.8	25	2	X-1	882459
[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Cutterhead

Class-No.

Ident-No.

Set Screws	M5x10			
Clamping Bars	B=10	G, O-1, O-2	995161	881087
Clamping Bars	B=18	C-1, C-2	925300	164526
Clamping Bars	B=30	X-1, X-2	925300	164076
Magnetic Stops	1,0		925300	882473
	[mm]		997800	166094

150512 / 150521

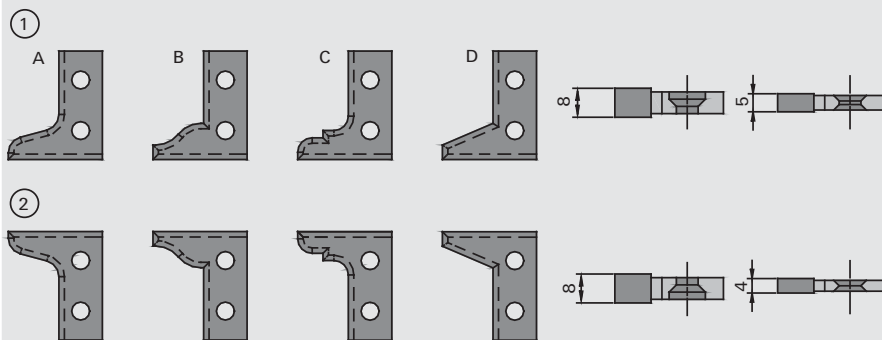
Modula Turnover Knives, Profile Knives HW

Product

Drawing



tungsten carbide [HW]



Machine / Application

l for length- and counterprofiles
in solid wood and wood-based
materials

Design

l number of teeth $Z = 2$

Advantages

Notes

l type 1 for cutterheads
lefthand X-1
l type 2 for cutterheads
righthand X-2

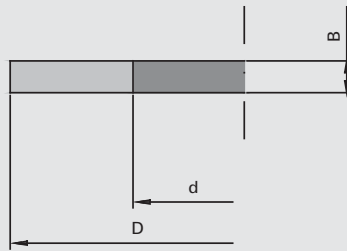
	B	H	S	Type	Ident-No.
grooving knives l + r	4	13			881180
grooving knives l + r	5	13			879870
grooving knives left	8			X-1	882483
grooving knives right	8			X-2	882460
raker	12	12	1.5		003080
raker	20	12	1.5	W, G	003082
profile A left	30	26	2	C-1	882465
profile A right	30	26	2	X-1	882466
profile B left	30	26	2	X-2	882463
profile B right	30	26	2		882464
profile C left	30	26	2		882461
profile C right	30	26	2		882462
profile D left	30	26	2		882467
profile D right	30	26	2		882468
	[mm]	[mm]	[mm]		

955520

Modula Spacers

Product

Drawing



Machine / Application

Design

Advantages

Notes

I special spacers with double
keyway for Modula tool system

Ø D	B	Ø d	DKN	Ident-No.
40	20	25	DKN	879880
40	10	25	DKN	879881
40	6	25	DKN	879882
40	5	25	DKN	879883
40	4	25	DKN	879884
40	2	25	DKN	879885
40	1	25	DKN	879886
40	1	25	DKN set 3x0,2 + 4x0,1	881178
40	0,5	25	DKN	879887
40	0,2	25	DKN	881029
40	0,1	25	DKN	881028
[mm]	[mm]	[mm]	[mm]	

985700

Modula Mounting Sets

Product		Drawing		
Machine / Application	Design	Advantages	Notes	
			all Modula cutterheads and sets will be generally supplied without mounting tools; therefore please order the complete mounting-set once the supplied Ø 25mm arbor allows for simplest changing of the cutterheads	
				Ident-No.
complete mounting-set				9210474
Content Mounting Set	Dimension	Class-No.	Ident-No.	
Screwdrivers	T20	985730	9210391	
Screwdrivers	T15x80	985730	171188	
Magnetic Stops	0,5	997800	166093	
Magnetic Stops	1,0	997800	166094	
Copper Paste		993420	879330	
Torque Screwdrivers		985730	9210355	
Hexagon Insert	SW2,5	985730	9210356	
Screwdrivers	SW4x100	985730	166091	
Screwdrivers	SW6	985730	881191	
Mounting Aids	Ø25	995122	881194	
		[mm]		

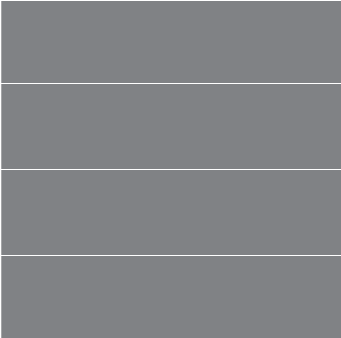
985700

Mounting device for tools with HSK 63

Product



Drawing



Machine / Application

Design

Advantages

Notes

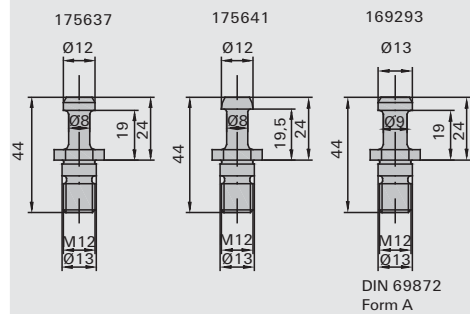
- | for collet chucks, SINO clamping system and change of turnover knives etc.
- | Tool-Support: with clamp lever for torsion protection; tiltable with latch at 90°; simple and secure handling
- | Combi-Grip: especially for Sino clamping system; secure grip by roller clamp

	Ø d	Ident-No.
Kombi-Grip	HSK 63E + F	199874
tool-man	HSK 63F	9215520
replacement clamping ring	HSK 63F	9205048
	[mm]	

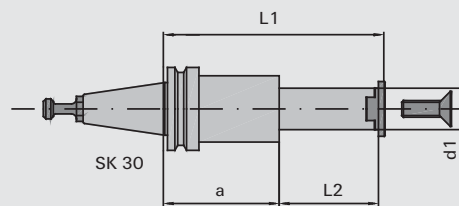
997200

Adapters SK 30

Product



Drawing

LEUCO
CNC

Machine / Application

for mounting of Modula sets or single cutters

Design

machine adapter SK 30
steep angle taper according to DIN 69871 without dog and locating grooves
for clockwise and counter-clockwise rotation
anti-twist protection by means of spline
incl. clamping lid

Advantages

Notes

please order retaining bolt separately
the clamping length is determined by application; please always state requested dimensions L2 and A

Ø d	Ø d1min	L2	L1	a	Ident-No.
SK 30	25	25-70	118	45	198971
SK 30	25	25-70	143	70	198973
SK 30	25	25-70	163	90	198975
SK 30	30	25-70	163		198977
[mm]	[mm]	[mm]	[mm]	[mm]	

Spare parts

Class-No.

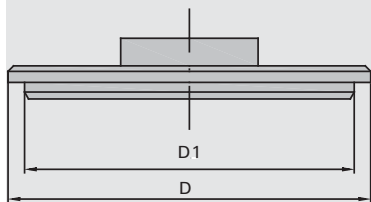
Ident-No.

Retention Knobs	up to 08/92	997870	175637
Retention knobs	for SK 30	997870	169293
Retention knobs	Ø 12 mm - HSD motor	997870	173641
Pivot Bolts	35-60 mm	985720	881177

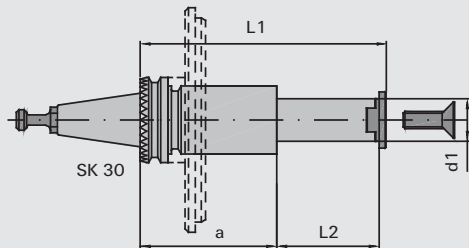
997200

Tool Adapters SK 30 with ring gear

Product



Drawing


LEUCO
CNC

Machine / Application

for mounting of Modula sets or single cutters

Design

- for adapter SK 30 Morbidelli and SCM
- for clockwise and counter-clockwise rotation
- anti-twist protection by means of spline
- incl. clamping lid

Advantages

Notes

- for Morbidelli 510 and SCM storage lids are not needed
- for Morbidelli 503 and 504 a storage lid is necessary (to be ordered separately)
- the clamping length is determined by application; please always state requested dimensions L2 and A

Ø d	Ø d1min	L2	L1	a	Ident-No.
SK 30 [mm]	25 [mm]	25-70 [mm]	154 [mm]	80 [mm]	882166

Spare parts

Class-No.

Ident-No.

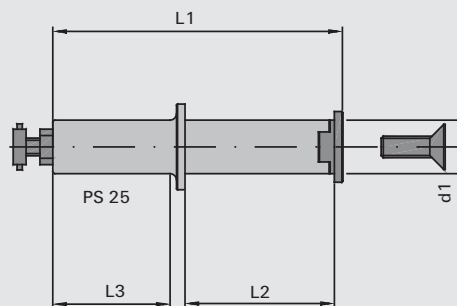
Retention Knobs	Morbidelli, SCM	997870	173646
Storage Lids	Morbidelli 503/504 Ø 125 mm	997300	882311
Storage Lids	Morbidelli 503/504 Ø 135 mm	997300	882308

997200

Adapters PS 25

Product

Drawing

LEUCO
CNC

Machine / Application

for mounting of Modula sets or single cutters

Design

machine adapter PS 25 or collets
for clockwise and counter-clockwise rotation
anti-twist protection by means of spline
incl. clamping lid

Advantages

Notes

clamping length depending on application; please always state dimension L2

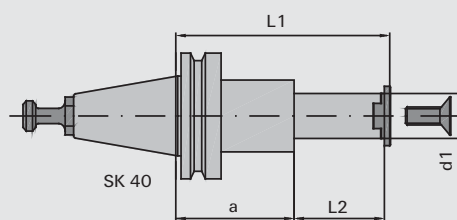
Ø d	L3	Ø d1min	L2	L1	Ident-No.
PS 25	126	25	4,5	135	199708
PS 25	113	25	12,5	135	198953
PS 25	101	25	25	135	198956
PS 25	81	25	45	135	198958
PS 25	55	25	71	135	198960
[mm]	[mm]	[mm]	[mm]	[mm]	

997200

Adapters SK 40

Product

Drawing

LEUCO
CNC

Machine / Application

for mounting of Modula sets or single cutters

Design

machine adapter SK 40
steep angle taper according to DIN 69871 without dog and locating grooves
for clockwise and counter-clockwise rotation
anti-twist protection by means of spline
incl. clamping lid

Advantages

Notes

incl. retaining bolt according to DIN 69871A
the clamping length is determined by application; please always state requested dimensions L2 and A

Ø d	Ø d1min	L2	L1	a	Ident-No.
SK 40	25	25-70	118	45	198979
SK 40	25	25-70	143	70	198981
SK 40	25	25-70	163	90	198983
SK 40	30	25-80	163		198985
[mm]	[mm]	[mm]	[mm]	[mm]	

Spare parts

Class-No.

Ident-No.

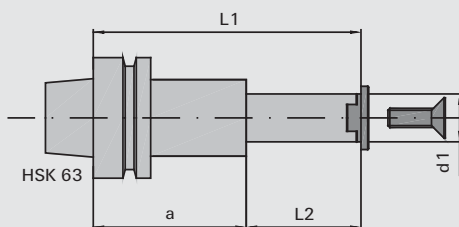
Retention knobs	up to 08/92	997870	169294
Pivot Bolts	35-60 mm	985720	881177

997200

Adapters HSK 63

Product

Drawing

LEUCO
CNC

Machine / Application

for mounting of Modula sets or single cutters

Design

machine adapter HSK 63F
for clockwise and counter-clockwise rotation
anti-twist protection by means of spline
incl. clamping lid

Advantages

Notes

incl. retaining bolt according to DIN 69871A
the clamping length is determined by application; please always state requested dimensions L2 and A

Ø d	Ø d1 min	L2	L1	a	Ident-No.
HSK 63F	25	25-87	137	50	199720 &
HSK 63F	25	25-71	151	80	198967 &
HSK 63F	25	25-71	171	100	199719 &
HSK 63F	30	25-80	160		198968 &
[mm]	[mm]	[mm]	[mm]	[mm]	

Spare parts

Dimension

Class-No.

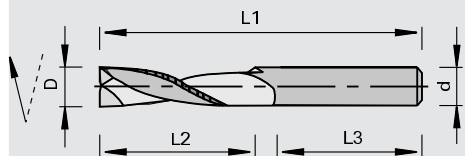
Ident-No.

Pivot Bolts	35-60	985720	881177
	[mm]		

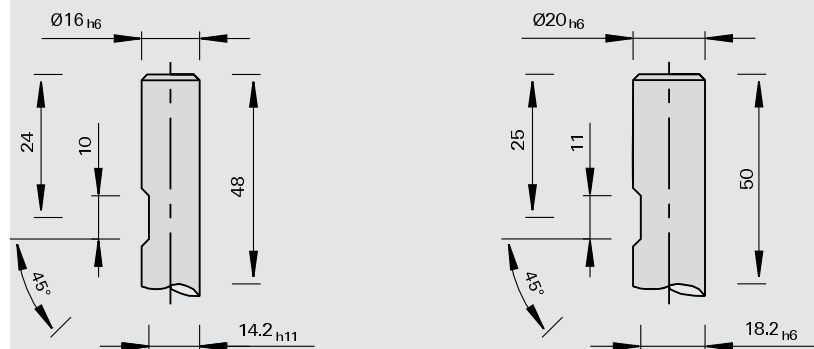
Solid Tungsten Carbide Shank-Type Cutters

Shank design for finishing cutter with chip breakers Class-No. 129460

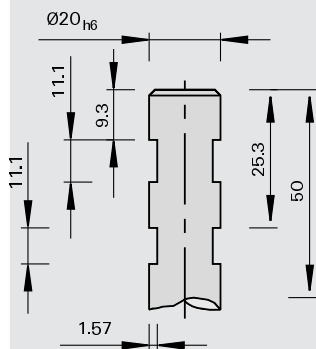
Cylindrical shank without clamping surface



For clamping in spacer sleeves according to DIN 6359 also called Weldon chuck

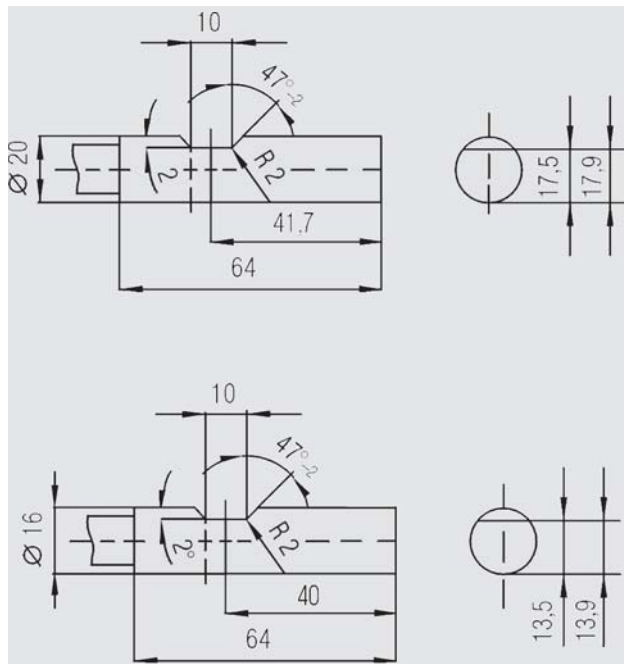


For clamping in special clamping chucks by MAKAL

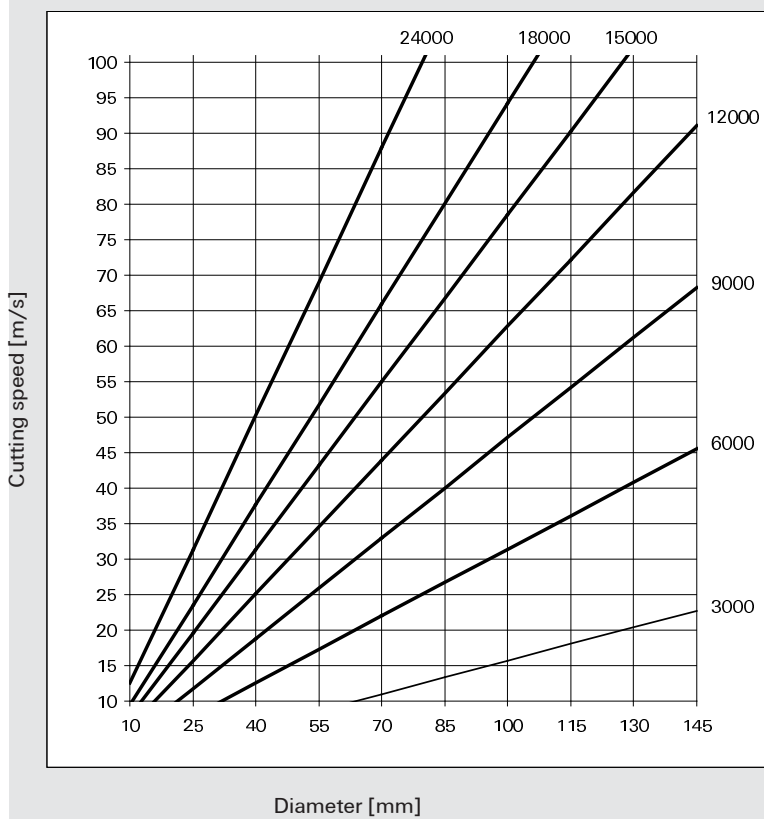


Clamping surface on Shank-Type Cutters

Particularly for solid carbide Lock-Case Cutters used in horizontal drilling/-milling aggregates of Homag and Weeke.



Determination of RPM [min-1]



Order / Inquiry for Special Tools: Shank-Type Cutters

Please copy and send the completed form to one of the LEUCO sales offices. (Only one tool description per form)

Customer-no.:	_____	Order:	☐
Company:	_____	Inquiry:	☐
Plant:	_____		
Street:	_____	Delivery (week no.):	_____
Zip / City:	_____	(Not binding)	
Country:	_____	No. of pieces:	_____
Contact partner:	_____		
Phone:	_____	Fax:	_____
City and Date:	_____	Signature:	_____

Machine

Make: _____

Model: _____

Motor output [kW]: _____

RPM range [min-1]: _____

Feed rate [m/min]: _____

Workpiece material

Description: _____

Cutting quality:

Trimming cut	☐
Finish cut	☐

Direction of cut:

With grain	☐
Across grain	☐
Yes ☐ No ☐	

Coating

Description: _____

Further Information _____

Tool

With tipped cutting edges: ☐

With exchangeable cutting edges:

EcoPro Cutterhead	☐
SuperProfiler	☐
UltraProfiler	☐
Standard	☐

Cutting diameter D [mm]: _____

Cutting length L2 [mm]: _____

Cutting width B [mm]: _____

Overall length L1 [mm]: _____

Shank length L3 [mm]: _____

Shank design:

Cylindrical shank [Ø]: _____

Other shank types [MK2, HSK F63, ...] _____

Only solid carbide cutters: shank design [no.] _____

Type of feed:	MAN	☐	☐
Sense of rotation:	Left	☐	Right ☐
Only solid carbide cutters: spiral	Positive	☐	Negative ☐
No. of teeth [pcs.]:			
Rakers:	_____		
Spur:	_____		
Grooving knives:	_____		
Edge breaker:	_____		
Arrangement of cutting edges:			
Only peripheral cutting		☐	
With face cutting edge		☐	
With plunge tip		☐	
Shear angle:	Single-sided	☐	Alternate ☐

Cutting material

Carbide	☐	Diamond	☐
ST	☐	HS	☐
Face side:	Top ☐	Bottom	☐

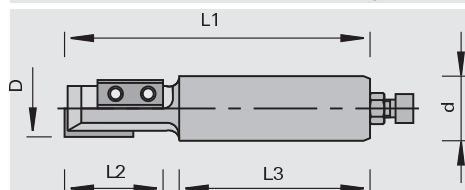
☐ check if applicable

Please indicate the following on workpiece samples or drawings:

Bottom side of workpiece	Dimension
Sense of rotation	Application conditions
Motor spindle	Profile drawing
Workpiece support	Tool drawing

Please indicate clearly if the workpiece or the tool is shown.

Please indicate additional dimension and markings in the tool drawing.



519-01.0708

